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SERVICE MANUAL



 **LOMBARDINI**
SERVICE

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1 GENERAL REMARKS AND SAFETY

1.1	PURPOSE OF THE MANUAL	5
1.2	USING THIS MANUAL	5
1.3	MANUFACTURER AND ENGINE IDENTIFICATION ..	5
1.4	GLOSSARY AND TERMINOLOGY	6
1.5	WARRANTY CLAUSES	6
1.6	GENERAL SAFETY REGULATIONS	6
1.7	GENERAL SAFETY DURING OPERATING PHASES	6
1.8	SAFETY AND ENVIRONMENTAL IMPACT	7
1.9	PRECAUTIONS WHEN THE ENGINE IS INSTALLED ON THE MACHINE	7
1.10	PRECAUTIONS WHEN THE ENGINE IS ON THE ROTATING STAND	7

2 TECHNICAL INFORMATION

2.1	GENERAL DESCRIPTION OF THE ENGINE	9
2.2	TECHNICAL SPECIFICATIONS	10
2.3	CHARACTERISTIC CURVE DIAGRAMS	12
2.4	ALTERNATOR LOAD CURVE DIAGRAMS	13
2.5	LUBRICANTS	14
2.5.1	SAE Classification	14
2.5.2	API/MIL sequences	14
2.5.3	ACEA Standards	14
2.5.4	Recommended oil	14
2.6	OPERATING PRINCIPLE FOR LUBRICATION	15
2.7	OPERATING PRINCIPLE FOR COOLING	15
2.8	OPERATING PRINCIPLE FOR FUEL INJECTION ...	16
2.9	WIRING DIAGRAM	17
2.10	SPECIAL TOOLS AND EQUIPMENT FOR MAINTENANCE	19
2.11	TABLE OF TIGHTENING TORQUES	19
2.12	TABLE OF SEALANTS	21
2.13	ROUTINE ENGINE MAINTENANCE	21

3 MALFUNCTIONS

3.1	LOOKING FOR MALFUNCTIONS	23
-----	--------------------------------	----

4 STORING THE ENGINE

4.1	HANDLING AND LIFTING	25
4.2	STORING THE ENGINE (UNINSTALLED)	25
4.3	STORING THE ENGINE (INSTALLED)	25
4.4	PROTECTIVE TREATMENT	26
4.5	PREPARING THE ENGINE FOR OPERATION (UNINSTALLED)	26
4.7	PREPARING THE ENGINE FOR OPERATION (INSTALLED)	27

5 REMOVING THE ASSEMBLIES

5.1	RECOMMENDATIONS FOR REMOVING THE ASSEMBLIES	29
5.2	REMOVING THE EXHAUST AND INTAKE MANIFOLDS	29
5.2.1	Disassembling the intake manifold	29
5.2.2	Disassembling the exhaust manifold	30

5.3	REMOVING THE COOLING FAN BELT DRIVE	30
5.3.1	Disassembling the cooling fan belt (with external alternator)	31
5.3.2	Disassembling the cooling fan belt (with internal alternator)	31
5.4	REMOVING THE TIMING BELT DRIVE	31
5.4.1	Disassembling the timing belt casing	31
5.4.2	Disassembling the timing belt	32
5.4.3	Disassembling the pulleys (camshaft and crankshaft)	32
5.5	REMOVING THE CYLINDER HEAD	33
5.5.1	Disassembling the rocker arm cover	33
5.5.2	Disassembling the rocker arms	33
5.5.3	Disassembling the fuel pump	33
5.5.4	Disassembling the injection-pumps	34
5.5.5	Disassembling the precombustion chamber	34
5.5.6	Disassembling the speed governor and flow limiter	35
5.5.7	Disassembling the camshaft	36
5.5.8	Disassembling the cylinder head	36
5.6	REMOVING THE CRANK GEAR AND CRANKCASE	36
5.6.1	Disassembling the flywheel	36
5.6.2	Disassembling the oil pump	37
5.6.3	Disassembling the crankcase and crankshaft	38
5.6.4	Disassembling the connecting rod and piston	39
5.7	DISASSEMBLING THE VALVES	39
5.8	DISASSEMBLING THE PISTON	40

6 OVERHAULS AND TUNING

6.1	RECOMMENDATIONS FOR OVERHAULS AND TUNING	41
6.1.1	Shaft seals	41
6.1.2	O-rings	41
6.1.3	Bearings	41
6.2	OVERHAULING THE CRANK GEARS AND CRANKCASE	41
6.2.1	Overhauling cylinders and pistons	41
6.2.2	Dimensional check and overhaul of cylinders	42
6.2.3	Dimensional check and overhaul of pistons	42
6.2.4	Dimensional check of sealing rings	43
6.2.5	Dimensional check and overhaul of crankshaft	44
6.2.6	Dimensional check and overhaul of connecting rods	45
6.2.7	Checking parallelism of the connecting rod axes	45
6.2.8	Checking and overhauling the fuel pump	46
6.2.9	Overhauling the decanting device	47
6.3	OVERHAUL OF CYLINDER HEAD AND RELATED COMPONENTS	47
6.3.1	Checking and overhauling the cylinder head	47
6.3.2	Checking and overhauling the rocker arm pin	48
6.3.3	Checking and replacing the camshaft	49
6.3.4	Checking and replacing the fuel pump drive rod	50
6.3.5	Checking and overhauling the valves	51
6.3.6	Adjusting valve-rocker arm clearance	52
6.3.7	Checking clearance volume	52
6.3.8	Calibrating the injector	53
6.3.9	Checking and overhauling the speed governor	53
6.4	CHECKING TIMING BELT RATING	54
6.4.1	Valve adjustments	54
6.5	DIAGRAM OF TIMING BELT RATES	55
6.6	ADJUSTING STATIC INJECTION TIMING	55
6.7	BALANCING INJECTION-PUMP DELIVERY	58

6.8	ADJUSTING MINIMUM AND MAXIMUM IDLE SPEED RPMS	60
6.9	ADJUSTING INJECTION DELIVERY	60
6.9.1	Adjusting injection delivery (without dyno brake)	60
6.9.2	Adjusting injection delivery (with dyno brake)	61
6.10	CHECKING OIL PRESSURE	61

7 INSTALLATION OF ASSEMBLIES

7.1	RECOMMENDATIONS FOR INSTALLING THE ASSEMBLIES	63
7.2	PRE-ASSEMBLY OF SEALING RINGS – PISTONS	63
7.3	PRE-ASSEMBLY OF CONNECTING RODS – PISTONS	64
7.4	INSTALLING VALVES	64
7.4.1	Assembling the valves	64
7.5	INSTALLATION OF CRANK GEAR AND CRANKCASE	65
7.5.1	Installing piston/connecting rod - engine block	65
7.5.2	Assembling the crankshaft	66
7.5.3	Assembling the crankcase	66
7.5.4	Measuring crankshaft axial clearance	67
7.5.5	Assembling the crankshaft flange (flywheel side)	67
7.5.6	Installing the oil pump	68
7.5.7	Assembling the flywheel	69
7.6	INSTALLATION OF CYLINDER HEAD AND COMPONENTS.....	70
7.6.1	Assembling the precombustion chamber	70
7.6.2	Assembling the cylinder head	71
7.6.3	Assembling the camshaft	71
7.6.4	Assembling the speed governor and flow limiter	72
7.6.5	Assembling injection – pumps	73
7.6.6	Assembling the mechanical fuel pump	74
7.6.7	Assembling the rocker arms	75
7.6.8	Assembling the rocker arm cover	75
7.7	INSTALLING THE TIMING BELT DRIVE	76
7.7.1	Assembling the timing belt pulley	76
7.7.2	Assembling the timing belt	76
7.7.3	Assembling the belt drive cover	77
7.8	INSTALLATION OF THE COOLING FAN BELT DRIVE	78
7.8.1	Assembling the fan belt drive pulleys	78
7.8.2	Assembling the fan belt drive	79
7.8.3	Assembling the cooling fan	80
7.9	INSTALLING INTAKE AND EXHAUST MANIFOLDS	80
7.9.1	Assembling the exhaust manifold	80
7.9.2	Assembling the intake manifold	80

8 REPLACING PARTS

8.1	RECOMMENDATIONS FOR REPLACING PARTS ..	83
8.2	REPLACING THE ALTERNATOR – FAN BELT	83
8.3	REPLACING THE TIMING BELT	85
8.4	REPLACING THE OIL FILTER	85
8.5	REPLACING THE AIR FILTER	86
8.6	REPLACING THE ALTERNATOR	87
8.7	REPLACING THE STARTER MOTOR	87
8.8	REPLACING THE FLYWHEEL RING GEAR	88
8.9	REPLACING THE COOLANT THERMOSTAT	88
8.10	REPLACING THE COOLANT PUMP	89
8.11	REPLACING THE THERMOSTATIC VALVE	89
8.12	REPLACING THE NEGATIVE-PRESSURE VENT VALVE	90
8.13	REPLACING THE PRE-HEATING GLOW PLUGS ...	90
8.14	REPLACING INJECTOR PUMP PARTS	91
8.14.1	Pumping element replacement	91
8.14.2	Replacing the nozzle-injector	93
8.15	REPLACING THE COOLING FAN SUPPORT	93

INDEX	95
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1.1 PURPOSE OF THE MANUAL

- This manual was written by the manufacturer to provide technical and operating information to authorised **LOMBARDINI** after-sales service centres to carry out assembly, disassembly, overhauling, replacement and tuning operations.
- This information is provided by the manufacturer in its own language (Italian) and may be translated into other languages to satisfy legislative and/or commercial requirements.
- As well as employing good operating techniques and observing the right timing for operations, operators must read the information very carefully and comply with it scrupulously.
- Time spent reading this information will help to prevent health and safety risks and financial damage.
- Written information is accompanied by illustrations in order to facilitate your understanding of every step in the operating phases.

- Important remarks and features of the text are highlighted using symbols, which are explained below.



Danger – Attention

This indicates situations of grave danger, which, if ignored, may seriously threaten the health, and safety of individuals.



Caution – Warning

This indicates that it is necessary to take proper precautions to prevent any risk to the health and safety of individuals and avoid financial damage.



Important

This indicates particularly important technical information that should not be ignored.

1.2 USING THIS MANUAL

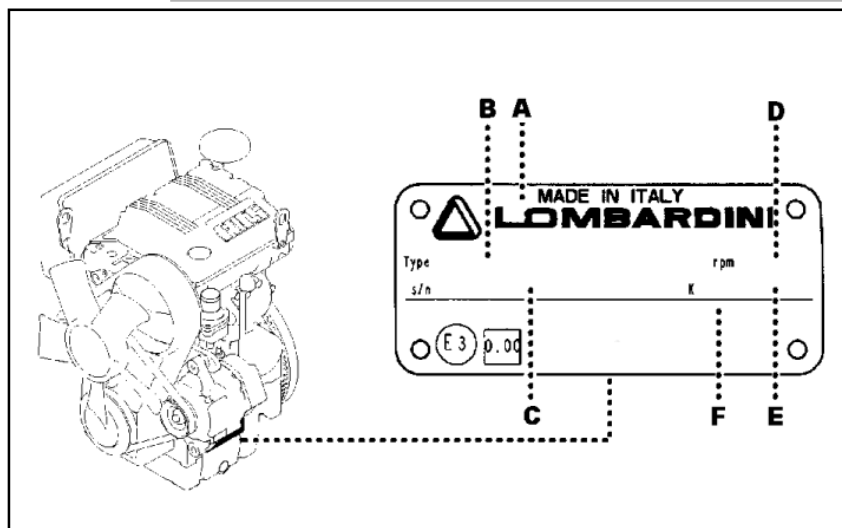
- This manual is divided into several chapters.
- The first chapter gives general information and details about safety (purpose of the manual, safety, etc.).
- The second, third and fourth chapters provide general technical information (technical specifications, diagrams, tightening torques, malfunctions, etc.).
- The fifth, sixth, seventh and eighth chapters describe the most important operating procedures (removal, overhaul and tuning, installation, replacements, etc.).

- This final section, which is reserved specifically for **LOMBARDINI** after-sales service centres, has been prepared with technical and practical considerations in mind.
- However, the actual sequence of operations that **LOMBARDINI** service centres must use may in some cases be different from the ones described in this manual. For this reason, the reader should refer to the index to find his/her topic of interest quickly.

1.3 MANUFACTURER AND ENGINE IDENTIFICATION

The identification plate shown in the figure can be found directly on the engine. It contains the model, engine identity and all information needed to operate safely.

- A) Manufacturer's identity
- B) Engine type
- C) Engine serial number
- D) Maximum speed
- E) Customer code
- E) Approval data



1.4 GLOSSARY AND TERMINOLOGY

For clarity, here are the definitions of a number of terms used recurrently in the manual.

- **Piston number one:** first piston “viewed from the flywheel side of the engine”.
- **Rotation direction:** clockwise or anticlockwise “viewed from the timing belt side of the engine”..

1.5 WARRANTY CLAUSES

LOMBARDINI issues a warranty certificate for each engine giving details of all relevant general terms.

1.6 GENERAL SAFETY REGULATIONS

- In designing and building its product, the manufacturer has paid particular attention to those aspects posing a risk to the health and safety of persons handling the engine. In addition to legislative requirements, all “rules for good technical construction” have been applied.
- The purpose of this information is to invite operators to pay particular attention in order to prevent any form of risk. Caution is always the best policy. Safety is also the responsibility of all operators who handle the
 - All persons carrying out work on the engine at any point in its life must possess precise technical qualifications and skills, as well as experience recognised and gained in the specific sector. Non-compliance with these requirements may cause damage to the health and safety of individuals.
 - Do not tamper with, sidestep, eliminate or bypass the installed safety devices. Non-compliance with this requirement may be hazardous to the health and safety of individuals.

1.7 GENERAL SAFETY DURING OPERATING PHASES

- The procedures contained in this manual have been tested and selected by the manufacturer’s technical experts, and hence are to be recognised as authorised operating methods.
- A number of procedures must be carried out with the aid of equipment and tools that simplify and improve the timing of operations.
- Some of these tools are normal workshop equipment, while others are specific instruments that have been constructed by the engine manufacturer.
- All tools must be in good working condition so that engine components are not damaged and that operations are carried out properly and safely.
- It is important to wear the personal safety devices prescribed by work safety laws and also by the standards of this manual.
- Holes must be lined up methodically and with the aid of suitable equipment. Do not use your fingers to carry out this operation to avoid the risk of amputation.
- Some phases may require the assistance of more than one operator. If so, it is important to inform and exercise them regarding the type of activity they will be performing in order to prevent risks to the health and safety of all persons involved.
- Do not use flammable liquids (petrol, diesel, etc.) to degrease or wash components. Use special products.
- Keep flames away from the engine to avoid the risk of fire.
- Replace worn or damaged parts exclusively with original LOMBARDINI spare parts. This will contribute to ensuring better performance and longer product life.

- Use the oils and greases recommended by the manufacturer. Do not mix different brands or oils with different characteristics.
- Use a torque wrench to tighten the main fixing points of engine components. Stick to the tightening torques indicated by the manufacturer.
- Discontinue use of the engine if any irregularities arise, particularly in the case of unusual vibrations.
- The engine has been designed and built to satisfy all the operating conditions described by the manufacturer.
- Do not tamper with any devices to alter the level of performance guaranteed by the manufacturer.

1.8 SAFETY AND ENVIRONMENTAL IMPACT

Every organisation has a duty to implement procedures to identify, assess and monitor the influence of its own activities (products, services, etc.) on the environment. Procedures for identifying the extent of the impact on the environment must consider the following factors:

- Liquid waste
- Waste management
- Soil contamination
- Atmospheric emissions
- Use of raw materials and natural resources
- Regulations and directives regarding environmental impact

In order to minimise the impact on the environment, the manufacturer now provides a number of indications to be followed by all persons handling the engine, for any reason, during its expected lifetime.

- All packaging components must be disposed of in accordance with the laws of the country in which disposal is taking place.
- Keep exhaust pipes in efficient working order to limit the noise level of the engine and reduce environmental pollution.
- When discontinuing use of the engine, select all components according to their chemical characteristics and dispose of separately.

1.9 PRECAUTIONS WHEN THE ENGINE IS INSTALLED ON THE MACHINE

- All operations, except where expressly stated otherwise, must be carried out when the engine is not running and has cooled sufficiently to avoid the risk of burns.
- Do not keep the engine running in areas that are closed and inadequately ventilated. Take all necessary precautions to prevent a build up of exhaust fumes.

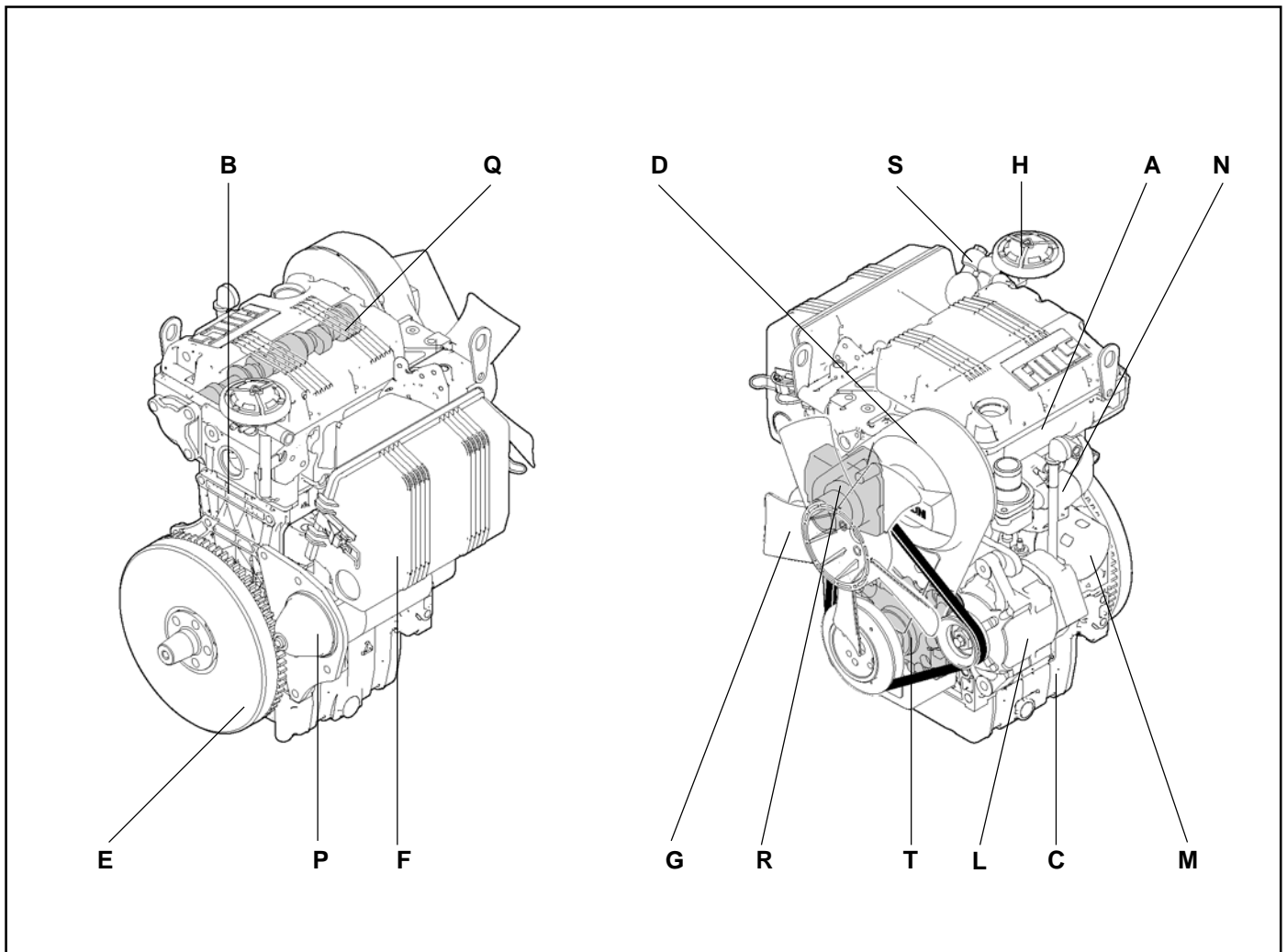
1.10 PRECAUTIONS WHEN THE ENGINE IS ON THE ROTATING STAND

- Before removing the engine from the machine on which it is installed, disconnect the electric current, the fuel supply, coolant and all connections including mechanical ones.
- To lift the engine, attach the lifting device at the points (eyebolts) specified by the manufacturer.
- Close all engine openings carefully (exhaust, intake, etc.) wash the outside and dry with a jet of compressed air.
- Anchor the engine to the rotating stand to facilitate all operations.

Note: the engine may also be placed on the workbench, depending on the type of work to be carried out.

2.1 GENERAL DESCRIPTION OF THE ENGINE

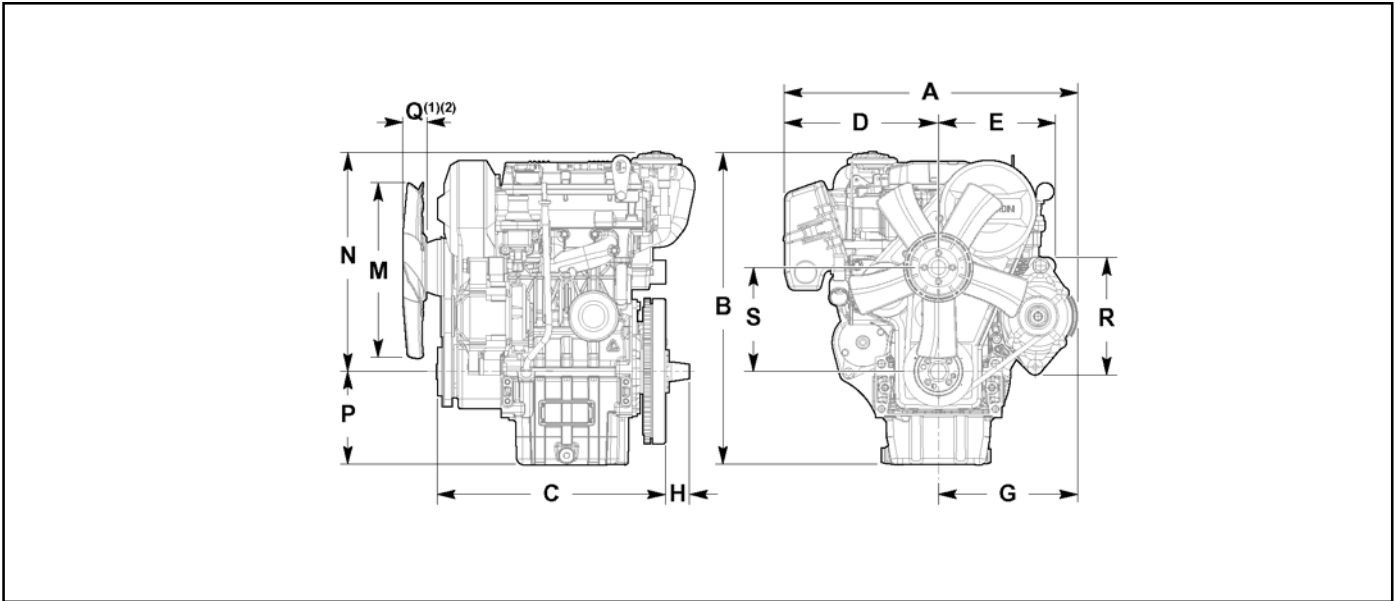
Main components



- A) Cylinder head
- B) Engine block
- C) Crankcase
- D) Timing belt assembly
- E) Flywheel and crankshaft assembly
- F) Air intake assembly
- G) Cooling fan
- H) Negative-pressure vent valve

- L) Alternator
- M) Oil filter
- N) Exhaust manifold
- P) Starter motor
- Q) Camshaft
- R) Coolant pump
- S) Fuel supply pump
- T) Oil pump

2.2 TECHNICAL SPECIFICATIONS



DIMENSIONS (mm)													
A	451	C	353	E	181	H	36	N	340	Q	51 ⁽¹⁾	R	182
B	491	D	238	G	213	M	280	P	151	Q	52 ⁽²⁾	S	160

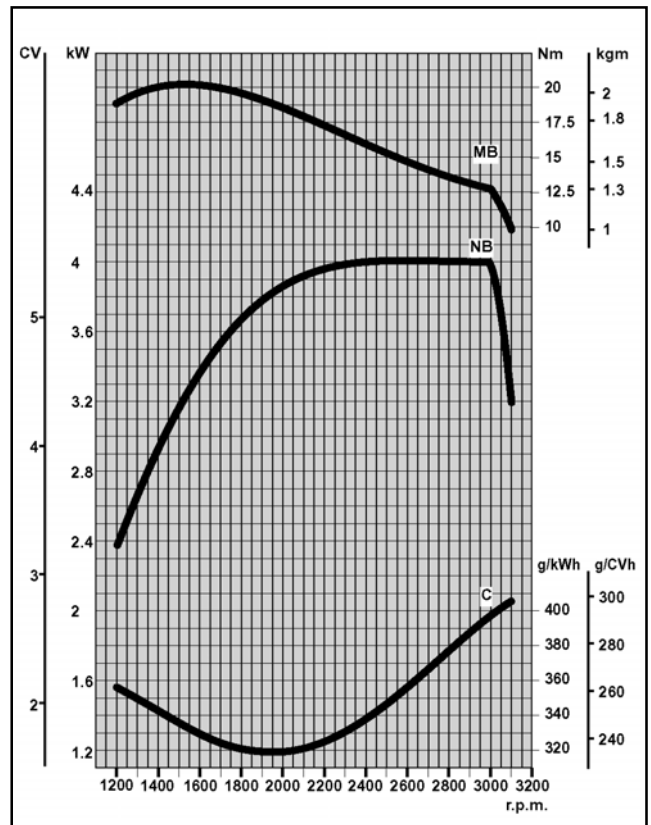
(1) with suction fan
(2) with blower fan

GENERAL DETAILS		
Operating cycle	4-stroke diesel	
Number of cylinders	n°	2
Bore x stroke	mm	72x62
Displacements	cm ³	505
Compression rate	22,8:1	
Intake	Air filter (dry)	
Filter capacity	µm	13÷14
Filtering surface	cm ²	4470
Cooling	Water	
Driving shaft rotation	Clockwise (from distribution side)	
Combustion sequence	1:2	
Timing system	Synchronous toothed belt	
Dry weight of engine	Kg	60
Maximum tilt while operating	no more than 1 minute	35°
Maximum tilt while operating	no more than 30 minutes	25°
Volume of air flow (at 3600 RPM)	l/min	910
Volume of cooling air (at 3600 RPM)	m ³ /min	36
POWER AND TORQUE		
Maximum operating speed	RPM	3600
Max. power (N 80/1269/EEC - ISO 1585 - DIN 7020)	kW (CV)	9.8 (13.4)
Max. power (NB ISO 3046 - 1 IFN - DIN 6270)	kW (CV)	9.1 (12.4)
Max. power (NA ISO 3046 - 1 ICXN - DIN 6270)	kW (CV)	8.2 (11.2)
Maximum torque (at 2400 RPM)	Nm	28.7
Axial load allowed on driving shaft	Kg	300

CONSUMPTION AT MAXIMUM POWER		
Specific fuel consumption	g/kWh	326
Specific oil consumption	Kg/h	0,007
SUPPLY CIRCUIT		
Supply type	Indirect injection	
Fuel type	Car diesel	
Fuel supply	Electric or membrane pump	
Fuel filter	Screw-on or in-line "fispino"	
<i>Filter paper</i>	m	PF905
<i>Filtering surface</i>	cm ²	2400
<i>Filter capacity</i>	μ	2÷3
<i>Maximum operating pressure</i>	bar	4
LUBRIFICATION CIRCUIT		
Type of lubrication	Completely forced	
Circuit supply	Trochoid pump	
Maximum oil quantity	including filter (l)	1,4
Maximum oil quantity	excluding filter (l)	1,3
Oil pressure at minimum speed (with oil temperature of 120°C)	no lower than 1 bar	
Oil filter cartridge		
<i>Maximum operating pressure</i>	bar	7
<i>Maximum combustion pressure</i>	bar	20
<i>Filter capacity</i>	μ	15
<i>By-pass valve setting</i>	bar	1,5÷1,7
<i>Filtering surface</i>	cm ²	730
COOLING CIRCUIT		
Coolant	50% water - 50% antifreeze fluid	
Thermostatic valve		
<i>Opening temperature</i>	°C	83°÷87°
<i>Max stroke (at 94°C)</i>	mm	7
<i>Liquid return</i>	l/h	30÷80
ELECTRICAL EQUIPMENT		
Nominal voltage	V	12
Alternator (nominal voltage)	V	14
Internal/external alternator (nominal current) (see "Alternator load curve diagrams")	A	40
Starter motor power	Kw	1,1
Preheating glow plugs		
<i>Nominal voltage</i>	V	12,5
<i>Absorption (after 5 seconds)</i>	A	12÷14
<i>Surface temperature of the sheath</i>	°C	850°
Control unit temperature sensor		
<i>Working field</i>	°C	-30°÷80°
<i>Voltage</i>	V	6+24
<i>Max. temperature</i>	°C	150°
Oil pressure switch		
<i>Operating pressure</i>	bar	0,15÷0,45
Coolant temperature monitoring sensor		
<i>Electric circuit</i>	Unipolar system	
<i>Supply voltage</i>	V	6÷24
<i>Absorbed power</i>	W	3
<i>Closed circuit temperature</i>	°C	107°÷113°

2.3 CHARACTERISTIC CURVE DIAGRAMS

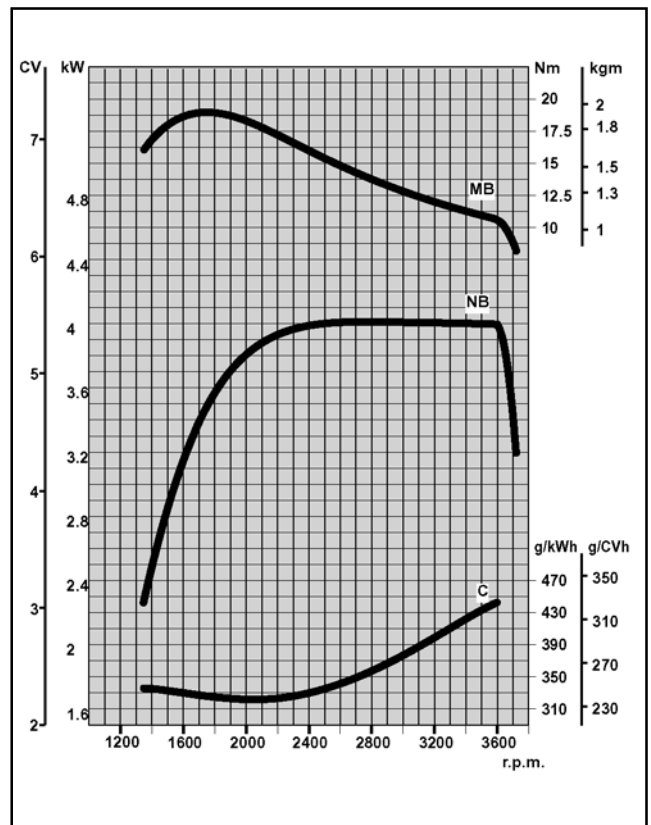
Power curve diagram 80/1269/CEE - 95/1/CE (3000 rpm)



Caption

- NB** = Power curve
- MB** = Torque curve
- C** = Specific consumption curve

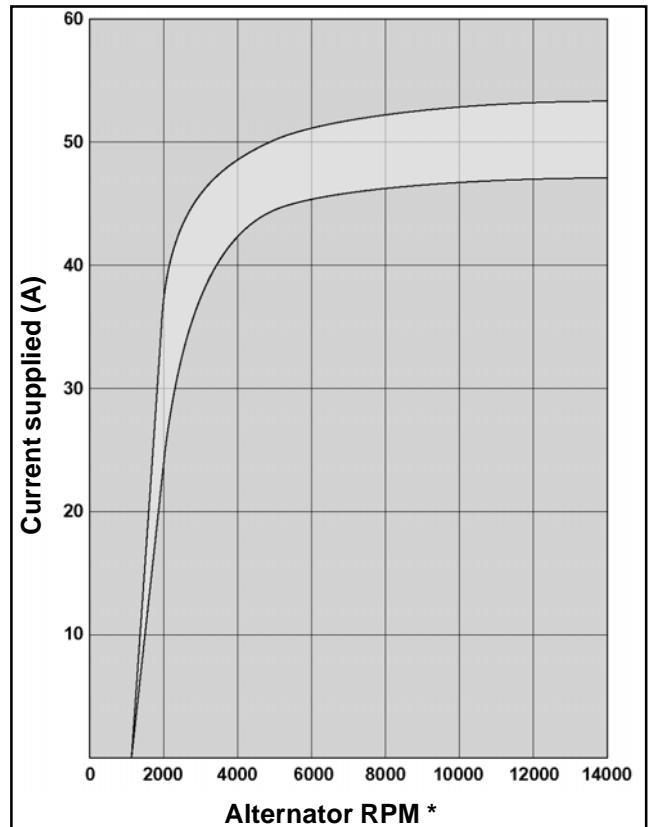
Power curve diagram 80/1269/CEE - 95/1/CE (3600 rpm)



2.4 ALTERNATOR LOAD CURVE DIAGRAMS

Reading taken after heat stabilisation at 25°C and constant voltage 13,5V.

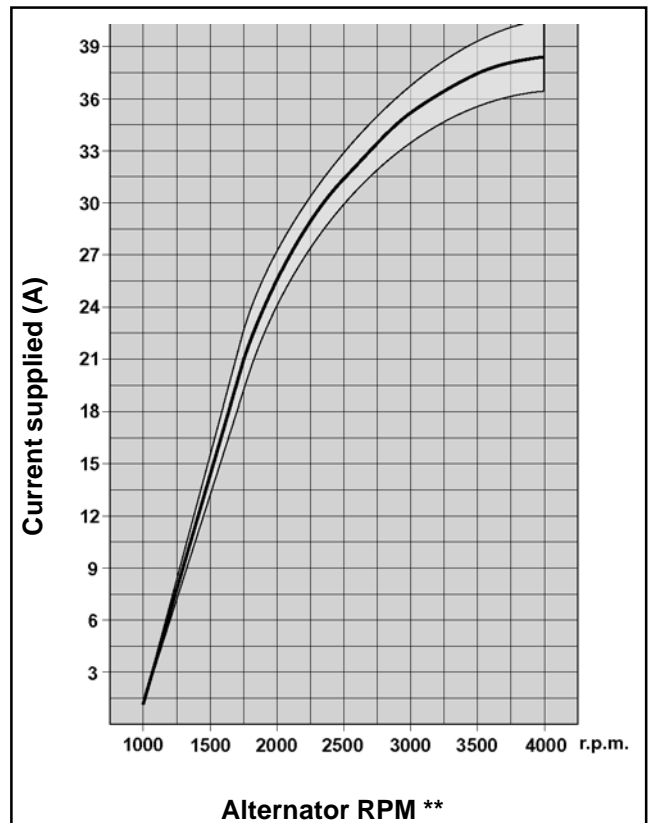
Internal load curve diagram



* To determine engine r.p.m.s, check the gear ratio adapted to pulleys.

Reading taken after heat stabilisation at 20°C and constant voltage 12,5V.

External load curve diagram

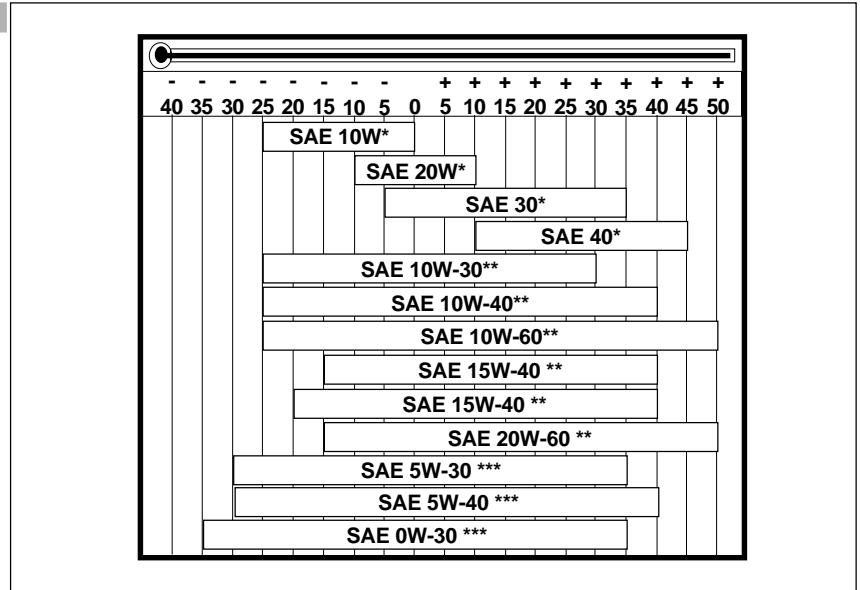


** The alternator turns at the same rate as the engines.

2.5 LUBRICANTS

2.5.1 SAE Classification

In the SAE classification, oils differ on the basis of their viscosity, and no other qualitative characteristic is taken into account. The first number refers to the viscosity when the engine is cold (symbol W = winter), while the second considers viscosity with the engine at régime. The criteria for choosing must consider, during winter, the lowest outside temperature to which the engine will be subject and the highest functioning temperature during summer. Single-degree oils are normally used when the running temperature varies scarcely. Multi-degree oil is less sensitive to temperature changes.



* Mineral base
 ** Semi-synthetic base
 *** Synthetic base

Key to abbreviations

A.P.I. : (American Petroleum Institute)
 MIL : USA military specifications for engine oils issued for logistic reasons
 ACEA : European Automobile Manufacturers Association

2.5.2 API/MIL Sequences

	DIESEL										BENZINA - ESSENCE - PETROL BENZIN - GASOLINA - GASOLINA									
API	CH-4	CG-4	CF-4	CF-2	CF	CE	CD	CC	CB	CA	SA	SB	SC	SD	SE	SF	SG	SH	SJ	SL
MIL						L - 2104 D / E					L - 46152 B / C / D / E									
	CORRENTI - CURRENT										OBSOLETE / OBSOLETE									

2.5.3 ACEA Standards - ACEA Sequences

PETROL

A1 = Low-viscosity, for friction reduction
A2 = Standard
A3 = High performance

LIGHT DUTY DIESELS

B1 = Low-viscosity, for friction reduction
B2 = Standard
B3 = High performance (indirect injection)
B4 = High quality (direct injection)

HEAVY DUTY DIESELS

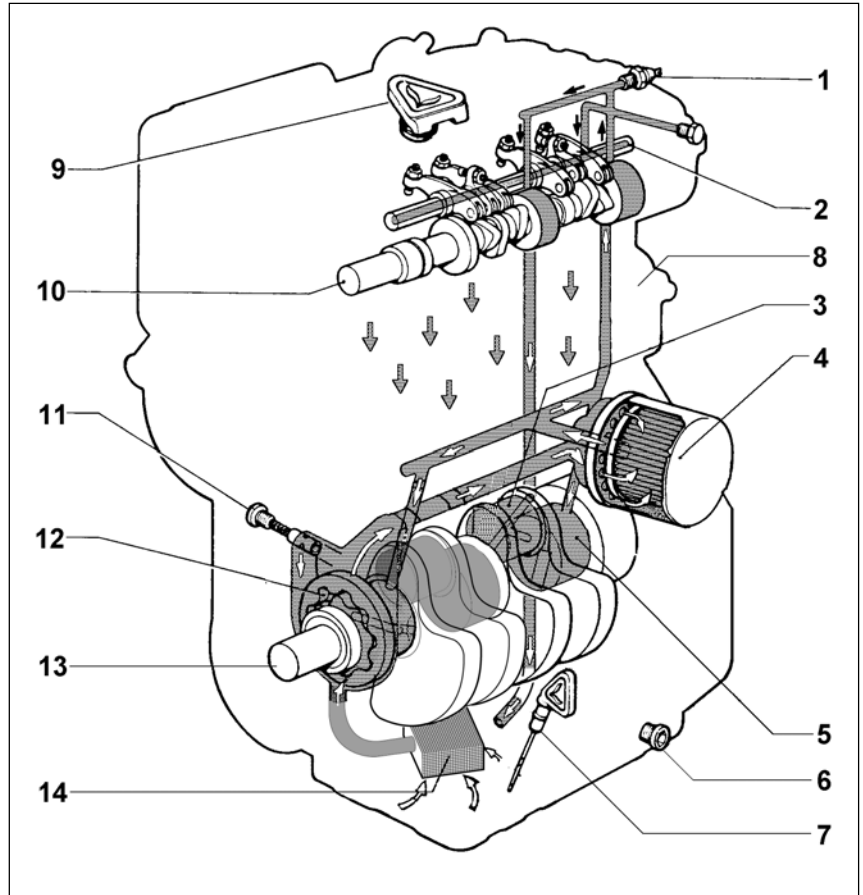
E1 = **OBSOLETE**
E2 = Standard
E3 = Heavy conditions (Euro1 - Euro2 engines)
E4 = Heavy conditions (Euro1 - Euro2 - Euro3)
E5 = High performance in heavy conditions (Euro1 - Euro2 - Euro3 engines)

2.5.4 Recommended oil

Description	Oil type	Oil characteristics
Engine oil	Agip SINT 2000 5W40	API SJ/CF ACEA A3-96 B3-96 MIL-L-4615 D/E

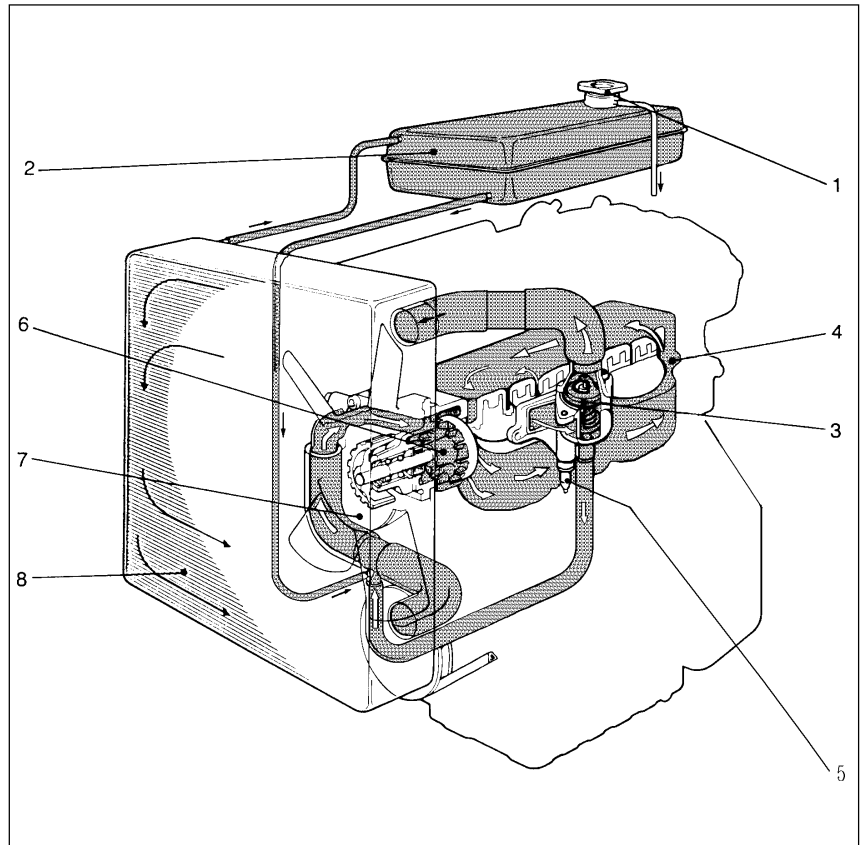
2.6 OPERATING PRINCIPLE FOR LUBRIFICATION

Ref.	Description
1	Pressure switch
2	Rocker-arm pin
3	Connecting rod big end pin
4	Oil filter cartridge
5	Main journal
6	Oil drain plug
7	Oil dipstick
8	Air vent
9	Oil refilling pump
10	Camshaft
11	Oil pressure regulating valve
12	Oil pump
13	Crankshaft
14	Oil suction filter



2.7 OPERATING PRINCIPLE FOR COOLING

Ref.	Description
1	Coolant refilling plug
2	Compensation tank
3	Thermostatic valve
4	Cylinder block
5	Liquid temperature monitoring thermostat
6	Circulating pump
7	Fan
8	Radiator

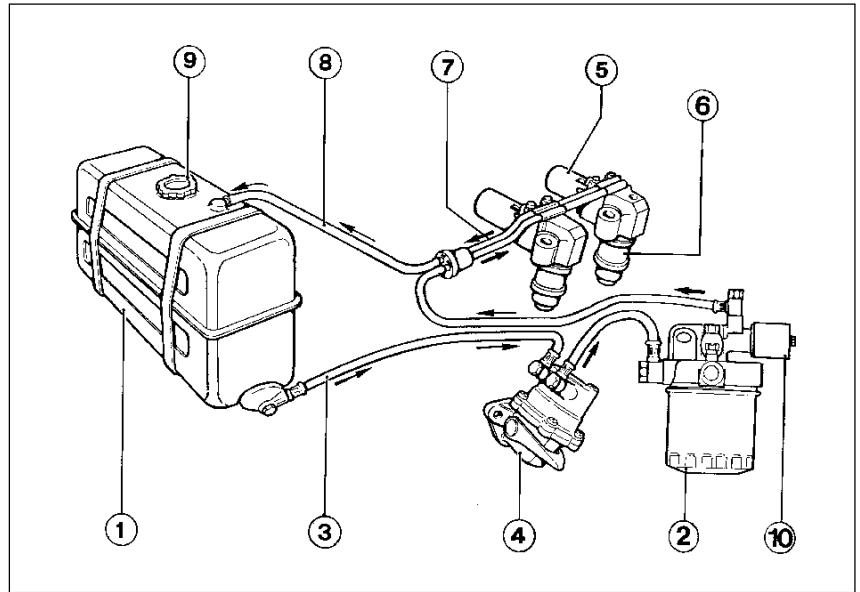


2.8 OPERATING PRINCIPLE FOR FUEL INJECTION

With mechanical supply pump

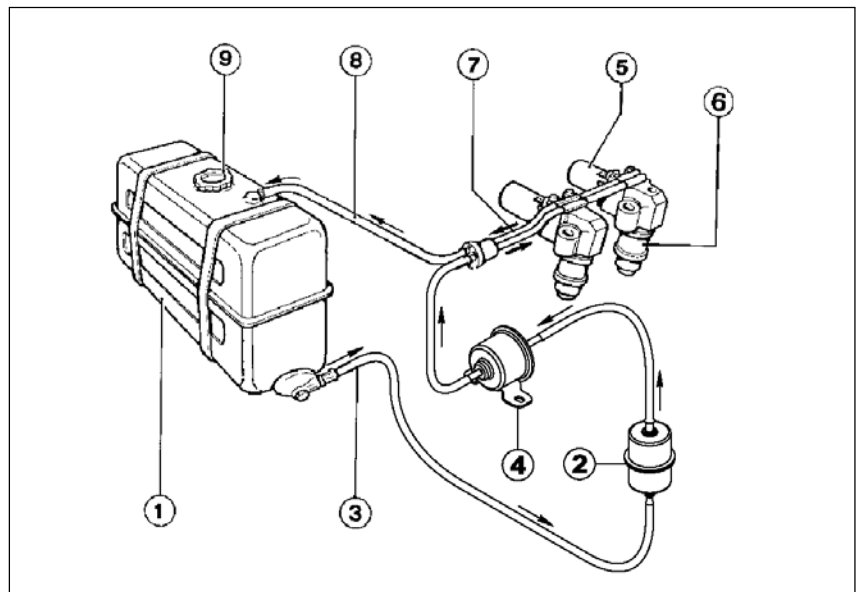
Ref.	Description
1	Tank
2	Fuel filter
3	Supply pipe
4	Supply pump
5	Injection pump
6	Injector
7	Fuel rail
8	Exhaust pipe
9	Plug
10	Solenoid valve

Note: the tank is supplied complete with filter on request.

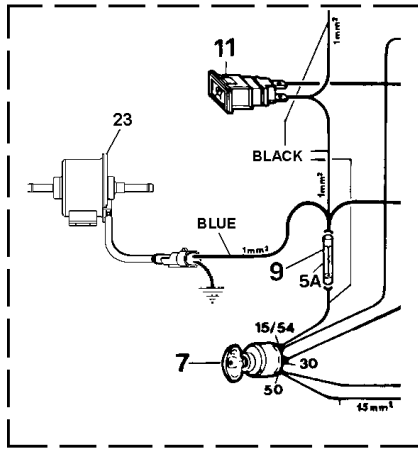


With electrical supply pump

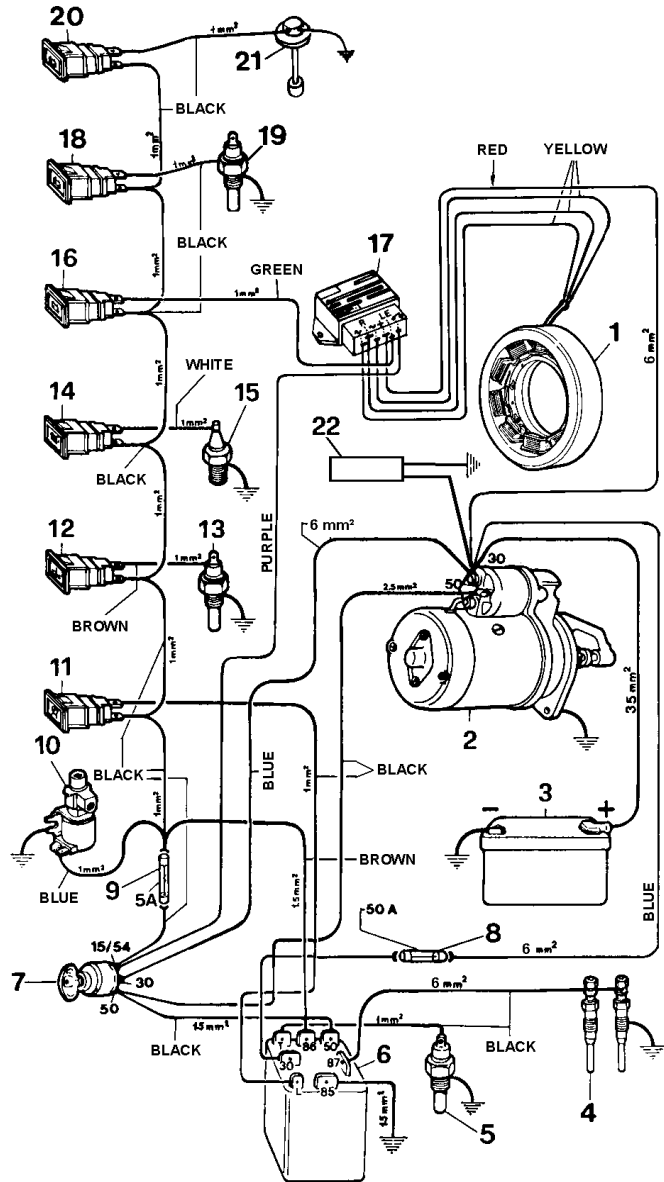
Ref.	Description
1	Tank
2	Fuel filter
3	Supply pipe
4	Electrical supply pump
5	Pump
6	Injector
7	Fuel rail
8	Exhaust pipe
9	Plug



With internal alternator



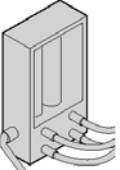
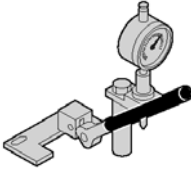
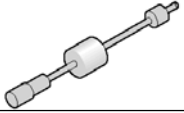







Electric pump version



Ref.	Description
1	40A alternator
2	Starter motor
3	Battery (recommended 44Ah-210A-DIN)
4	Preheating glow plugs
5	Coolant temperature monitoring sensor
6	Glow plug pre-heating control box
7	Ignition switch
8	50A fuses
9	5A fuses
10	Electrostop device or electrical fuel lift pump
11	Glow plugs indicator
12	Coolant temperature indicator

Ref.	Description
13	Coolant thermostat indicator light
14	Engine oil pressure lamp
15	Oil pressure gauge
16	Battery load indicator
17	Voltage regulator
18	Coolant thermometer
19	Coolant thermometer sensor
20	Fuel level light
21	Fuel level indicator
22	25 V - 10000 µF condenser
23	Electrical fuel lift pump

2.10 SPECIAL TOOLS AND EQUIPMENT FOR MAINTANANCE









Serial number	Description	Serial number	Description
7107-1460-127 	Instrument for balancing injection pump delivery	7107-1460-048 	Tool for lowering injection advance control valve
7107-1460-030 	Precombustion chamber extractor	7107-1460-074 	Equipment for injection advance control and injector calibration
7107-1460-029 	Pin wrench for ring nut on pump/injector pumping element	7107-1460-051 	Driving shaft clamping tool
7107-1460-027 	Precombustion chamber pin wrench	7107-1460-031 	Pivot pin precombustion chamber
7107-1460-047 	Tool for mounting intake/exhaust valve guide gasket	7271-1460-049 	Tool for adjusting timing belt tension

2.11 TABLE FOR TIGHTENING TORQUES









The table shows the tightening torques for standard screws and the main components.

Tightening torques are provided again, along with method and sequence, in the instructions for assembling components and/or assemblies.

Tightening torques for standard screws (coarse thread)

Quality / Dimensions	Resistance class (R)							
								
	R>400N/mm ²		R>500N/mm ²		R>600N/mm ²	R>800N/mm ²	R>1000N/mm ²	R>1200N/mm ²
Diameter	Nm	Nm	Nm	Nm	Nm	Nm	Nm	Nm
M3	0,5	0,7	0,6	0,9	1	1,4	1,9	2,3
M4	1,1	1,5	1,4	1,8	2,2	2,9	4,1	4,9
M5	2,3	3	2,8	3,8	4,5	6	8,5	10
M6	3,8	5	4,7	6,3	7,5	10	14	17
M8	9,4	13	12	16	19	25	35	41
M10	18	25	23	31	37	49	69	83
M12	32	43	40	54	65	86	120	145
M14	51	68	63	84	101	135	190	230
M16	79	105	98	131	158	210	295	355
M18	109	145	135	181	218	290	405	485
M20	154	205	193	256	308	410	580	690
M22	206	275	260	344	413	550	780	930
M24	266	355	333	444	533	710	1000	1200
M27	394	525	500	656	788	1050	1500	1800
M30	544	725	680	906	1088	1450	2000	2400

Tightening torques for standard screws (fine threads)

Quality / Dimensions	Resistance class (R)							
								
	R>400N/mm ²		R>500N/mm ²		R>600N/mm ²	R>800N/mm ²	R>1000N/mm ²	R>1200N/mm ²
Diameter	Nm	Nm	Nm	Nm	Nm	Nm	Nm	Nm
M 8x1	10	14	13	17	20	27	38	45
M 10x1	21	28	26	35	42	56	79	95
M 10x1,25	20	26	24	33	39	52	73	88
M 12x1,25	36	48	45	59	71	95	135	160
M 12x1,5	38	45	42	56	68	90	125	150
M 14x1,5	56	75	70	94	113	150	210	250
M 16x1,5	84	113	105	141	169	225	315	380
M 18x1,5	122	163	153	203	244	325	460	550
M 18x2	117	157	147	196	235	313	440	530
M 20x1,5	173	230	213	288	345	460	640	770
M 20x2	164	218	204	273	327	436	615	740
M 22x1,5	229	305	287	381	458	610	860	1050
M 24x2	293	390	367	488	585	780	1100	1300
M 27x2	431	575	533	719	863	1150	1600	1950
M 30x2	600	800	750	1000	1200	1600	2250	2700

Tightening torques for main components

Description	Diameter x thread	Tightening torque (Nm)
Injector pump connecting rod	M 3 spéc.	1,2
Aluminium connecting rod	8x1	30
Steel connecting rod	8x1	50
Preheating glow plugs	12x1,25	25
Rocker-arm cover	6x1	9
Crankcase (screws for fixing crankshaft)	M 10	30
Crankcase (screws for fixing engine block)	M 6	10
Screw for speed governor bearing support cover	M 6	10
Preheating glow plugs cable nuts	5x0,8	5
Fuel supply pump nuts	8x1,5	24
Nut for synchronous timing belt pulley	M 10	40
Injector pump nut	8x1,25	20
Rocker arm support nuts	10x1,5	40
Fuel pump control eccentric	10x1,25	80
Oil sealing ring flange screws (flywheel side)	M 6	12
Precombustion chamber ring nut	30x1,5	180
Governor tinkage adjustment pin	6x1	7
Crankshaft pulley screw (timing belt side)	16x1,5 gauche	180
Camshaft pulley screw	10x1,25	80
Oil pressure switch	12x1,5	25
Oil plug	12x1,5	40
Cylinder head screws		(¹)
Injector pump head screws	TCEI 4x1,5	4
Flywheel screws	10x1,5	80
Coolant thermostat / Control unit sensor		30
Control unit temperature sensor		30

(¹) For more detailed information see "Assembling the cylinder head"

2.12 TABLE OF SEALANTS

Area of application	Sealant
Fuel rail attachment	Loctite 638
Oil filter cartridge union (M 20X1,5)	Loctite 601
Camshaft bearing screw (M 6)	Loctite 270
Stud bolt for tightening pulley (M 10)	Loctite 601
Cylinder head plug (ø 18)	Loctite 510
Engine and engine block cylinder head plug (ø 30)	Loctite 510

2.13 ROUTINE ENGINE MAINTENANCE

		After the first 500 Km	REGULARITY KM (per 1000 Km)																					
			5	10	15	20	25	30	35	40	45	50	55	60	65	70	75	80	85	90	95	100		
PROCEDURE	DETAIL																							
CLEANING	Pump injectors																							
	Radiator fan																							
CHECK	Valve and rocker arm clearance																							
	Engine oil		EVERY 2500 Km																					
	Solenoid valve operation																							
	Oil vapor recovery																							
	Fuel pipe and connections																							
	Coolant																							
	Alternator belt																							
	Timing belt		EVERY 25000 Km																					
	CHANGE	Alternator																						
		Air filter element																						
Engine oil			EVERY 5000 Km																					
Oil filter																								
Fuel filter																								
Coolant																								
Alternator belt																								
Timing belt			EVERY 50000 Km (or at every disassembly)																					
Fuel pipes			EVERY 4 years																					

3.1 LOOKING FOR MALFUNCTIONS

The following information is provided to help identify and correct any irregularities and malfunctions that may arise during use.

Probable cause		Problem										
		Engine does not start	Engine starts and then stops	Does not accelerate	Inconsistent rpm	Black smoke	White smoke	Low oil pressure	Oil consumption too high	Consumption huile en excès	Oil and condensation dripping from the exhaust	Coolant overheats
FUEL CIRCUIT	Clogged pipes											
	Clogged fuel filter											
	Air in the fuel circuit											
	Clogged tank breather											
	Faulty fuel pump											
	Blocked injector											
	Blocked injection pump valve											
	Injector not adjusted											
	Excess leaking in the plunger											
	Jammed injection pump delivery control											
	Wrong injection pump delivery setting											
LUBRIFICATION	High oil level											
	Blocked pressure relief valve											
	Worn oil pump											
	Air in the oil intake pipe											
	Faulty pressure gauge or switch											
	Clogged oil suction hose											
ELECTRICAL SYSTEM	Burnt fuse on pre-heating glow plugs											
	Failure in glow plugs control unit											
	Discharged battery											
	Inefficient or wrong cable connection											
	Faulty ignition switch											
	Faulty starter motor											
MAINTENANCE	Air filter clogged											
	Excessive idle operation											
	Incomplete running-in											
	Overloaded engine											
	Clogged cooling circuit											
	Slack or broken fan control belt											
ADJUSTMENTS / REPAIRS	Incorrect injection timing											
	Delayed injection											
	Incorrect governor linkage adjustment											
	Broken or loose governor spring											
	Low idle setting											
	Worn or stuck piston rings											
	Worn or scored cylinders											
	Worn valve guides											
	Valves stuck											
	Worn crankshaft/connecting rod bearings											
	Non-sliding speed governor leverage											
	Driving shaft not turning freely											
	Damaged head gasket											
Slack pump/injector control rod												
Incorrect pump/injector delivery balancing												

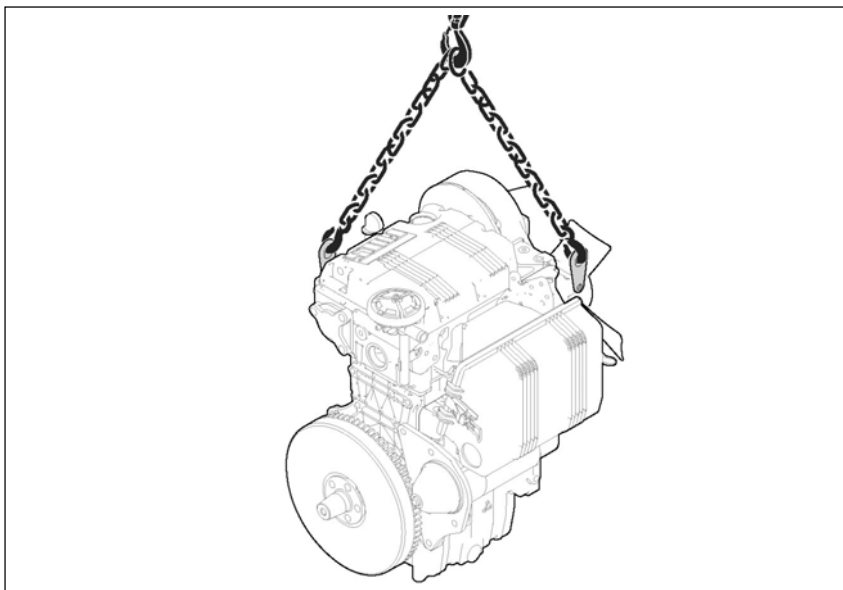
4.1 HANDLING AND LIFTING

- Secure the engine using a lifting device (lifting beam) of suitable capacity.
- Hook the lifting device to the points indicated in the drawing.
- Before lifting, check the load's centre of gravity.



Important

The dimensions of the brackets on the fastening points have been specially conceived to lift the engine and have not been tested for lifting additional weights. Do not lift the engine using different methods from those described. Non-observance of this requirement will invalidate the insurance warranty from any damages caused in this way.



4.2 STORING THE ENGINE (UNINSTALLED)

- If the engine is not to be used for extensive periods, check the surroundings and the type of packaging and make sure that they are suitable for correct storage. If necessary, cover the engine with a protective sheet.
- Avoid storing the engine directly on the ground or in an environment that is humid, exposed to bad weather or close to sources of danger, including less visible ones, such as high-voltage power lines etc.
- If the engine is not to be used for more than 1 month, it is necessary to apply the protective measures that are valid for 6 months (see "Protective treatment (first 6 months of inactivity)").
- If, after the first 6 months, the engine is still not to be used, it is necessary to carry out a further measure to extend the protection period (see "Protective treatment (after 6 months of inactivity)").

4.3 STORING THE ENGINE (INSTALLED)

If the engine has been installed on a machine and is not due to be used for extensive periods, it is necessary to carry out a few maintenance measures in order to ensure it remains efficient and to protect its components. If the engine is installed on the machine and is not to be used for short periods of time, the following measures must be carried out:

- Check the condition of the electrical contacts and protect them, if necessary, using an anti-rust spray.
- Disconnect the battery.
- Empty the fuel tank to prevent the risk of fire.

- Remove the key from the dashboard and put it in a safe place to avoid acts of vandalism.
- Lock the cabin and the cowls to prevent strangers getting access.

If the engine is not to be used for more than 1 month, it is necessary to apply protective measures that are valid for 6 months (see "Protective treatment").

If, after the first 6 months, the engine is still not to be used, it is necessary to carry out a further measure to extend the protection period (see "Protective treatment").

4.4 PROTECTIVE TREATMENT

- 1- Check that the engine oil and coolant are up to level.
- 2 - Start the engine and keep idle at minimum speed for 15 minutes.
- 3 - Switch off the engine and leave to cool.
- 4 - Take out the lubricant
- 5 - Fill the casing with AGIP RUSTIA C protective oil
- 6 - Empty the fuel tank completely.
- 7 - Replace fuel filter.
- 8 - Fill the fuel tank with a mixture made up of 10% AGIP RUSTIA NT protective oil and 90% fuel.
- 9 - Release the air from the fuel supply circuit.
- 10 - Start the engine and check for fuel leaks.
- 11 - Start the engine and bring to $\frac{3}{4}$ of the maximum speed for 5-10 minutes.
- 12 - Switch off the engine.
- 13 - Spray SAE 10W oil on the exhaust and intake

manifolds.

- 14 - Close all openings to prevent foreign bodies from entering.
- 15 - Thoroughly clean all external parts of the engine using suitable products.
- 16 - Treat non-painted parts with protective products (AGIP RUSTIA 100/F).
- 17 - Loosen the alternator-fan belt.
- 18 - If necessary, cover the engine with a protective sheet.



Important

After a year of engine inactivity, the coolant loses its properties and must be replaced

4.5 PREPARING THE ENGINE FOR OPERATION (UNINSTALLED)

After a period of inactivity and before installing and running the engine, it is necessary to carry out a few measures in order to ensure that it runs at maximum efficiency.

- 1 - Remove the protective treatment.
- 2 - Remove any blockages from the exhaust and intake ducts.
- 3 - Use a cloth soaked in degreasing product to remove the external protective treatment.
- 4 - Remove the intake manifold.
- 5 - Inject lubrication oil (no more than 2 cm³) into the valves and replace the intake manifold.
- 6 - Adjust the alternator-fan belt tension.
- 7 - Turn the flywheel manually to check the movement of the mechanical parts.
- 8 - Start the engine and run at $\frac{3}{4}$ of the maximum speed for 5-10 minutes.
- 9 - Switch off the engine.
- 10 - Remove the protective oil to replace with engine oil.
- 11 - Introduce new oil (see "Table of lubricants") up to the correct level marked on the dipstick.
- 12 - Check the filters for aging (air, oil, fuel) and, if necessary, replace them with original spares.



Important

Over time, a number of engine components and lubricants lose their properties, even when the engine is not in use, and so it is important to consider whether they need replacing, based not only on the number of hours of use, but also on age and wear.

- 13 - Install the engine onto the machine and make the necessary connections and unions.
- 14 - Make sure that electrical contacts are intact and efficient.
- 15 - Check that the engine oil and coolant are up to level.
- 16 - Start the engine and keep at minimum speed for a few minutes.
- 17 - Check for leaks and, if necessary, find and eliminate the cause.
- 18 - Switch off the engine.

4.6 PREPARING THE ENGINE FOR OPERATION (INSTALLED)

After a period of inactivity and before installing and running the engine, it is necessary to carry out a few measures in order to ensure that it runs at maximum efficiency.

- 1 - Use a cloth soaked in degreasing product to remove the external protective treatment.
- 2 - Adjust the alternator-fan belt tension.
- 3 - Make sure that electrical contacts are intact and efficient.
- 4 - Check the filters for aging (air, oil, fuel) and, if necessary, replace them with original spares.



Important

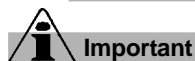
Over time, a number of engine components and lubricants lose their properties, even when the engine is not in use, and so it is important to consider whether they need replacing, based not only on the number of hours of use, but also on age and wear.

- 5 - Check that the engine oil and coolant are up to level.
- 6 - Start the engine and keep at minimum speed for a few minutes.
- 7 - Check for leaks and, if necessary, find and eliminate the cause.
- 8 - Switch off the engine.

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5.1 RACCOMENDATIONS FOR REMOVING THE ASSEMBLIES

- Information is given in a logical order in terms of timing and sequence of operations. The methods have been selected, tested and approved by the manufacturer's technical experts.
- This chapter describes procedures for removing assemblies and/or individual components, in order to carry out work on specific parts of the engine.
- See the chapter entitled "Overhauls and tuning" for operations involving checks, overhauls and tuning of assemblies and/or components.
- See the chapter entitled "Installation of assemblies" for operations involving the installation of assemblies and/or components.



To locate specific topics, the reader should refer to the index.

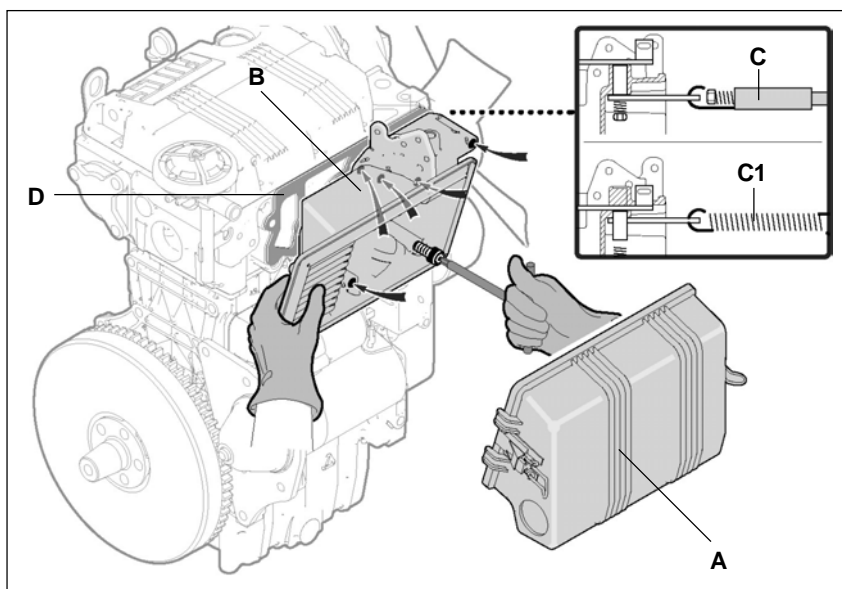
- Before any intervention, the operator should lay out all equipment and tools in such a way as to enable him to carry out operations correctly and safely.
- Before proceeding with operations, make sure that appropriate safety conditions are in place, in order to safeguard the operator and any persons involved.
- For safety and convenience, you are advised to place the engine on a special rotating stand for engine overhauls.

5.2 REMOVING THE EXHAUST AND INTAKE MANIFLODS

5.2.1 Disassembling the intake manifold

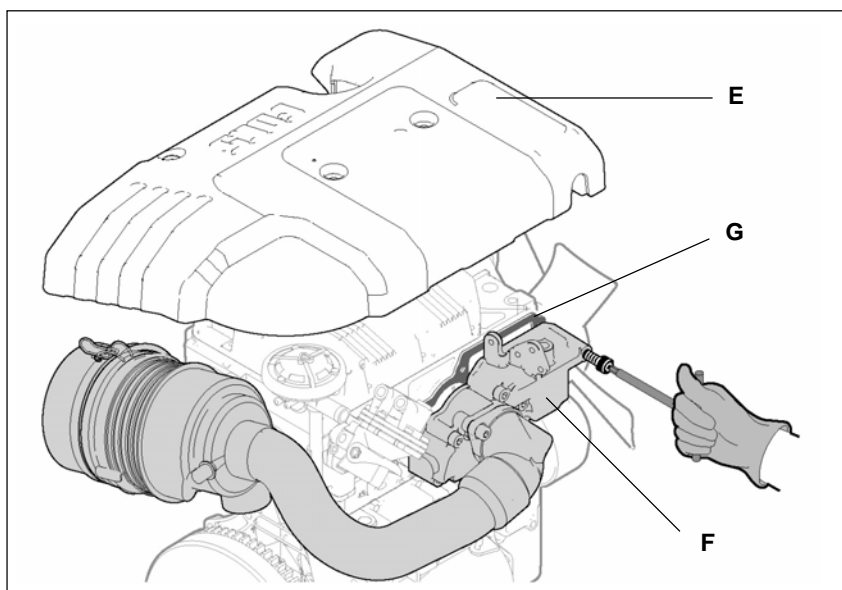
Air filter (square type)

- 1 - Remove the cover (A).
- 2 - Remove the intake manifold (B)
- 3 - Unhook the minimum-maximum device (C) or the spring (C1).
- 4 - Remove the gasket (D).
- 5 - Close the openings and ducts to prevent foreign bodies from entering.



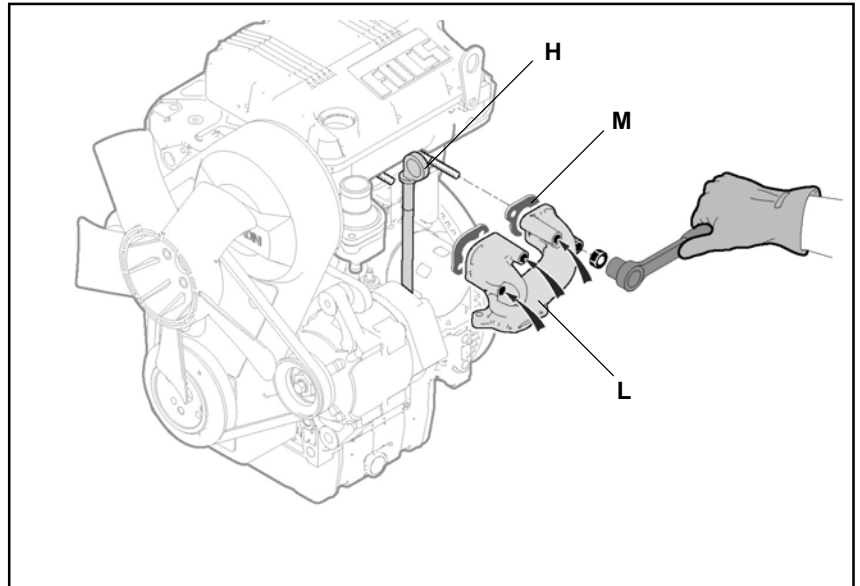
Air filter (cylindrical type)

- 1 - Remove the cover (E).
- 2 - Disconnect the intake and air vent pipes.
- 3 - Remove the intake manifold (F).
- 4 - Unhook the minimum-maximum device or the spring.
- 5 - Remove the gasket (G).
- 6 - Close the openings and ducts to prevent foreign bodies from entering.



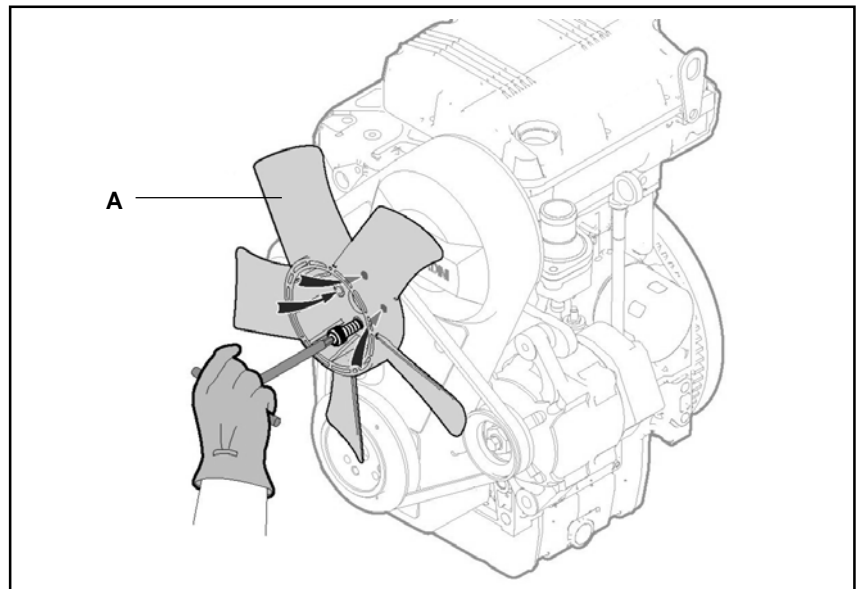
5.2.2 Disassembling the exhaust manifold

- 1 - Remove the dipstick tube (**H**).
- 2 - Remove the exhaust manifold (**L**).
- 3 - Remove the gaskets (**M**).
- 4 - Close the openings and ducts to prevent foreign bodies from entering.



5.3 REMOVING THE COOLING FAN BELT DRIVE

- 1 - Remove the cooling fan (**A**).

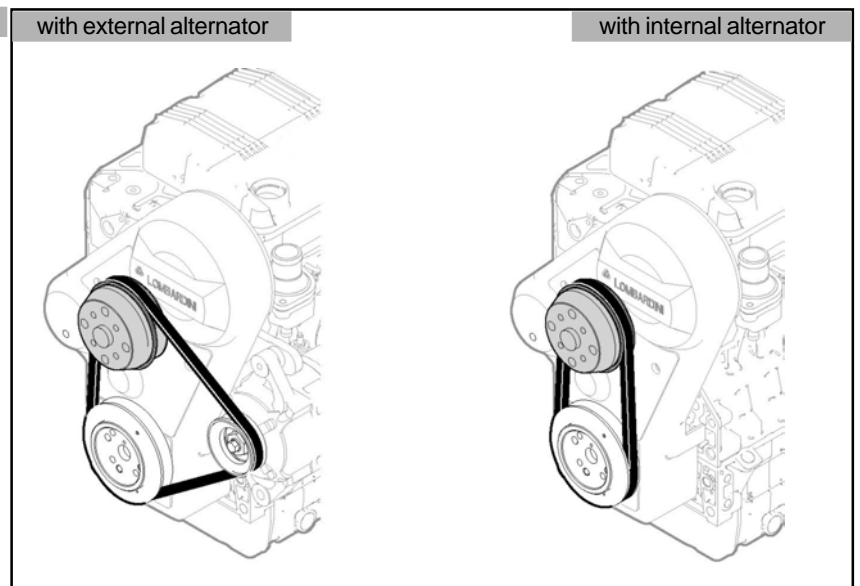


Important

The cooling fan belt drive comes in more than one version: with external or internal alternator.

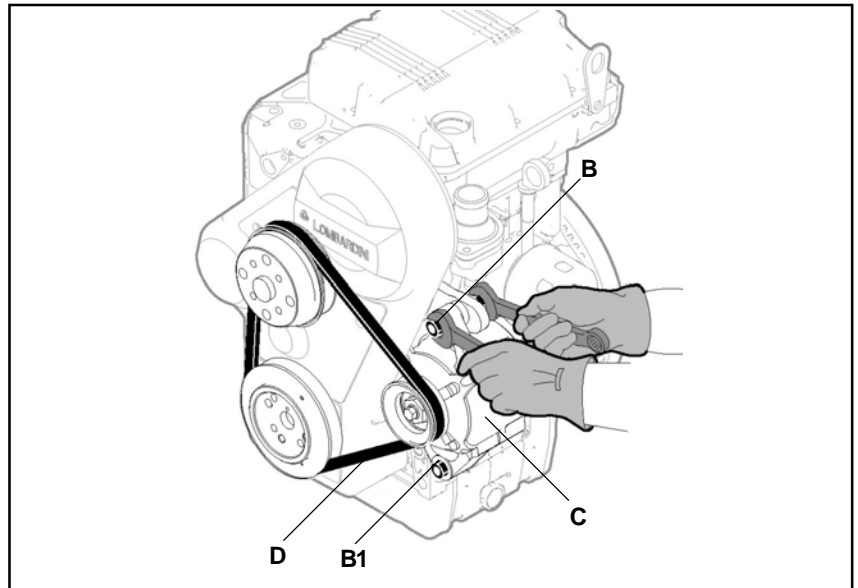
with external alternator

with internal alternator



5.3.1 Disassembling the cooling fan belt (with external alternator)

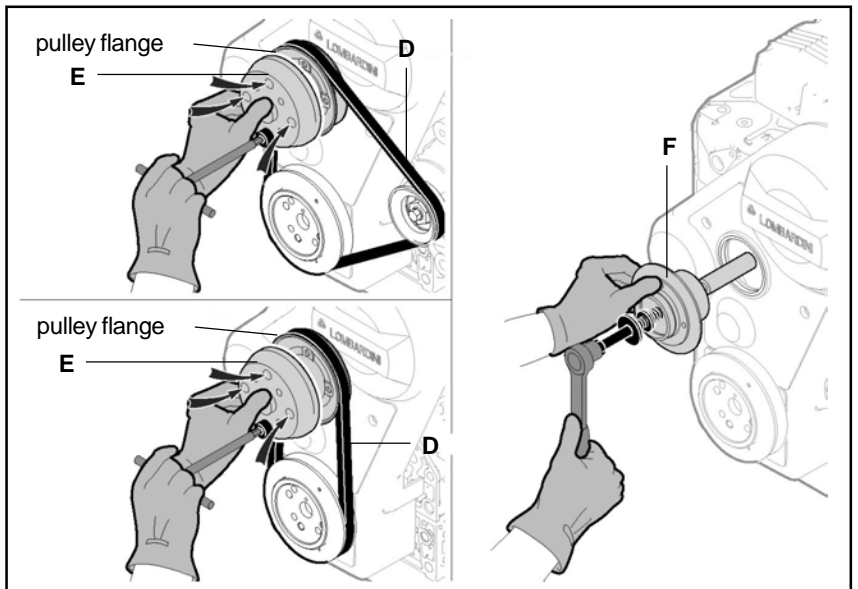
- 1 - Loosen the nuts (**B - B1**).
- 2 - Loosen the belt (**D**) by adjusting the alternator (**C**) manually.
- 3 - Remove the belt (**D**).



- 4 - Remove the hub (**E**) and flange.
- 5 - Remove the pulley (**F**), washers and spacer.

5.3.2 Disassembling the cooling fan belt (with internal alternator)

- 1 - Remove the hub (**E**) and flange.
- 2 - Remove the belt (**D**).
- 3 - Remove the pulley (**F**), washers and spacer.



5.4 REMOVING THE TIMING BELT

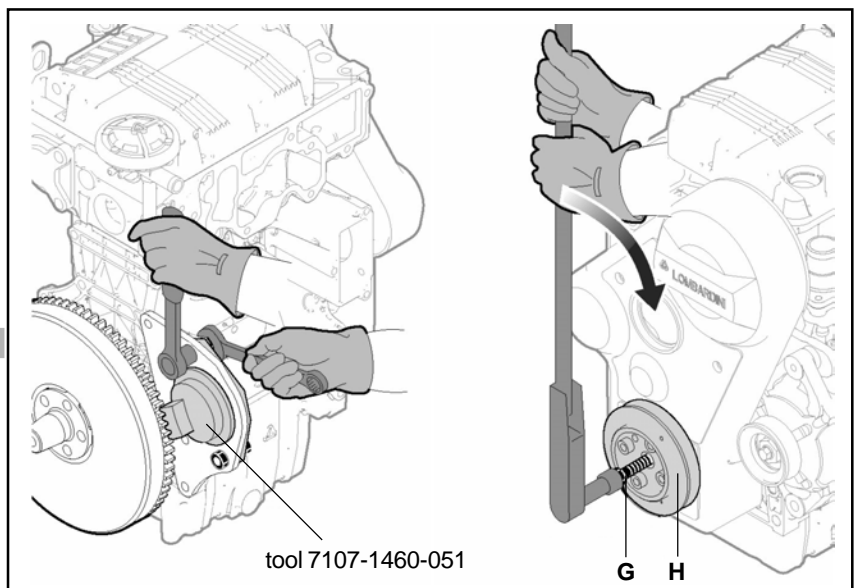
5.4.1 Disassembling the timing belt casing

- 1 - Disassemble the starter motor.
- 2 - Install tool "7107-1460-051" to inhibit rotation of the crankshaft.
- 3 - Loosen the screw (**G**).

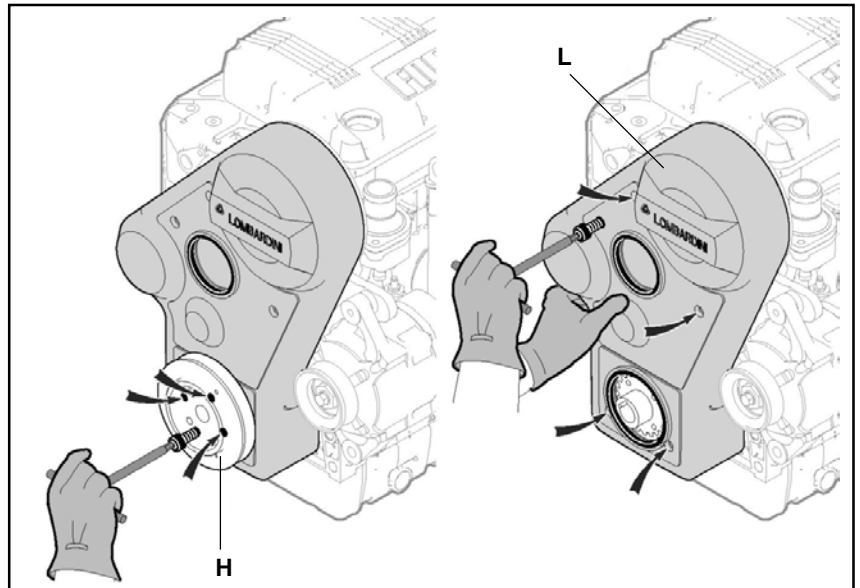


Caution - Warning

The screw is left-handed. Turn clockwise to unscrew.



- 4 - Loosen the screws and remove the pulley (H).
- 5 - Remove the casing (L).



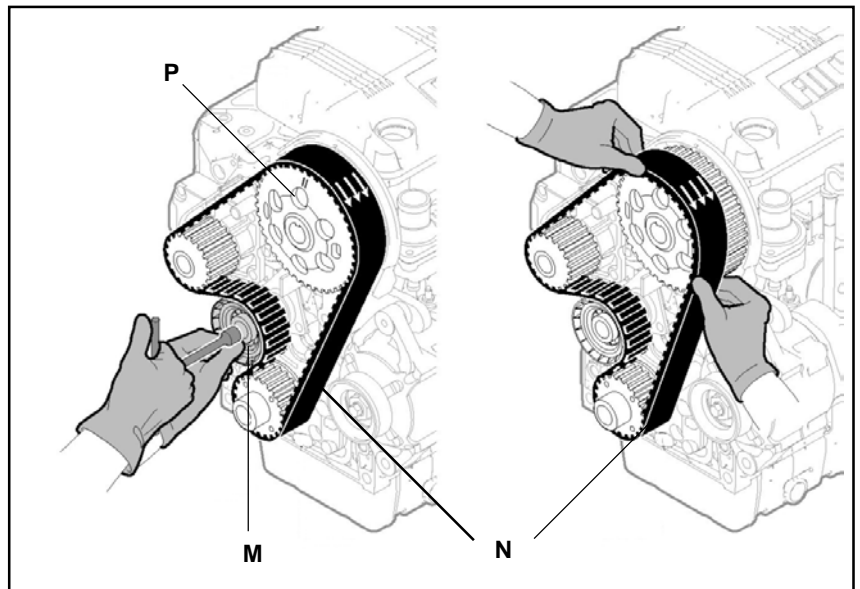
5.4.2 Disassembling the timing belt

- 1 - Twist the pulley nut (M) to fully loosen the belt (N).
- 2 - Remove the belt (N), working it away in sequence first from the pulley and (P) and then from the others.



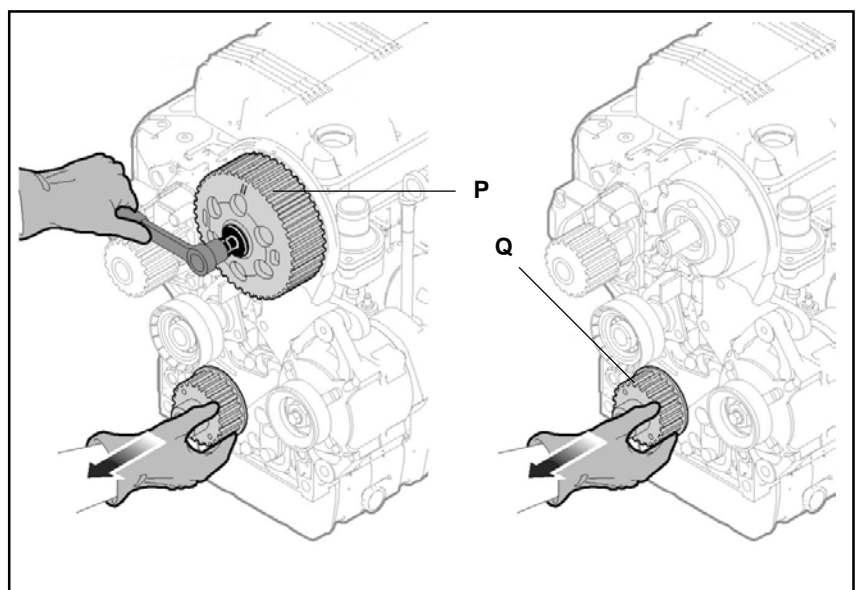
Important

The timing belt must always be replaced with an original spare part whenever it is removed.



5.4.3 Disassembling the pulleys (camshaft and crankshaft)

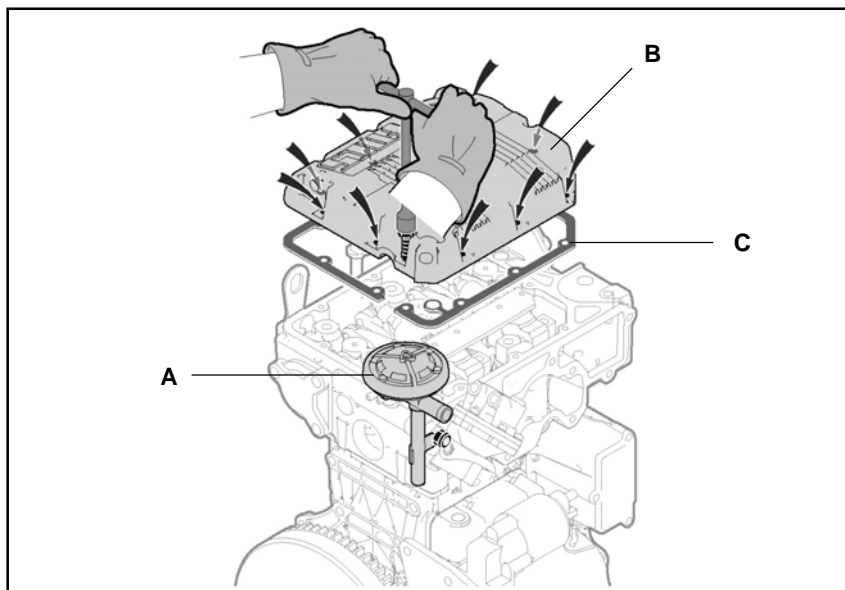
- 1 - Remove the pulley (P).
- 2 - Remove the pulley (Q).



5.5 REMOVING THE CYLINDER HEAD

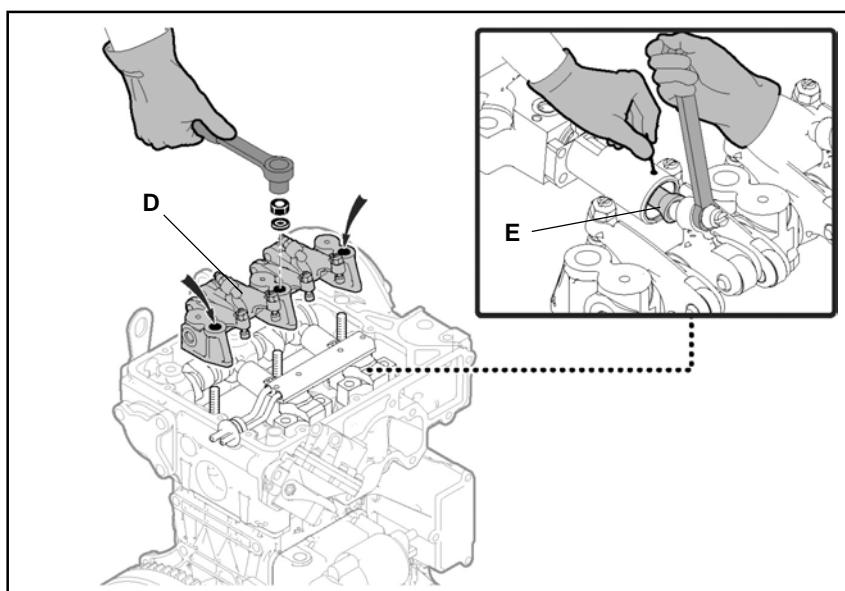
5.5.1 Disassembling the rocker arm cover

- 1 - Remove the negative-pressure vent valve (A).
- 2 - Remove the rocker arm cover (B).
- 3 - Remove the gasket (C).



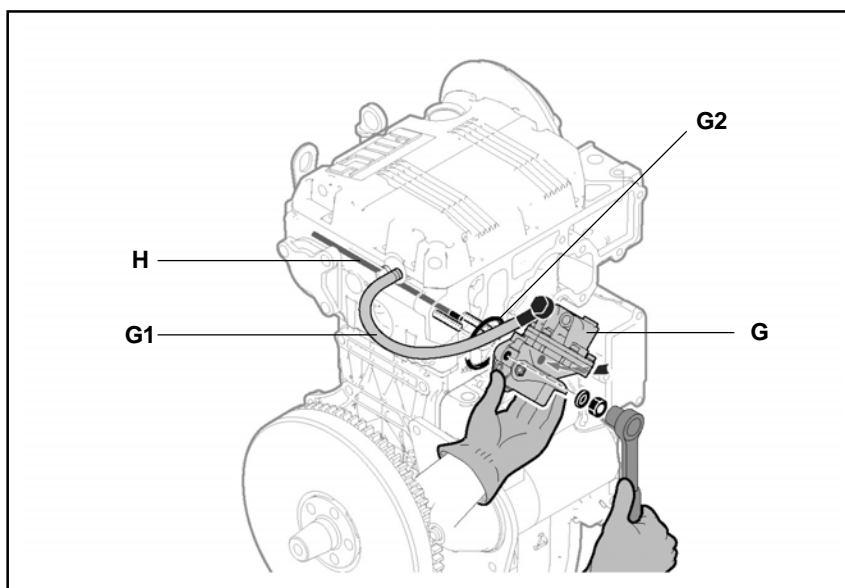
5.5.2 Disassembling the rocker arms

- 1 - Press the rocker arm to fully push the drive rod down (E).
- 2 - Introduce a pin to interrupt the injector stroke in order to be able to extract the drive rod.
- 3 - Let go of the rocker arm and remove the drive rod.
- 4 - Repeat the same operation on the other injector.
- 5 - Remove the rocker arm pin and support (D).



5.5.3 Disassembling the fuel pump

- 1 - Disconnect the supply pipe (G1) from the union.
- 2 - Remove the supply pump (G).
- 3 - Remove the O-ring (G2).
- 4 - Extract the drive rod (H).



5.5.4 Disassembling the injection-pumps

1 - Remove the fuel rail (F).

Important

Make sure that the injector gaskets remain in position.

2 - Unhook the spring (L).

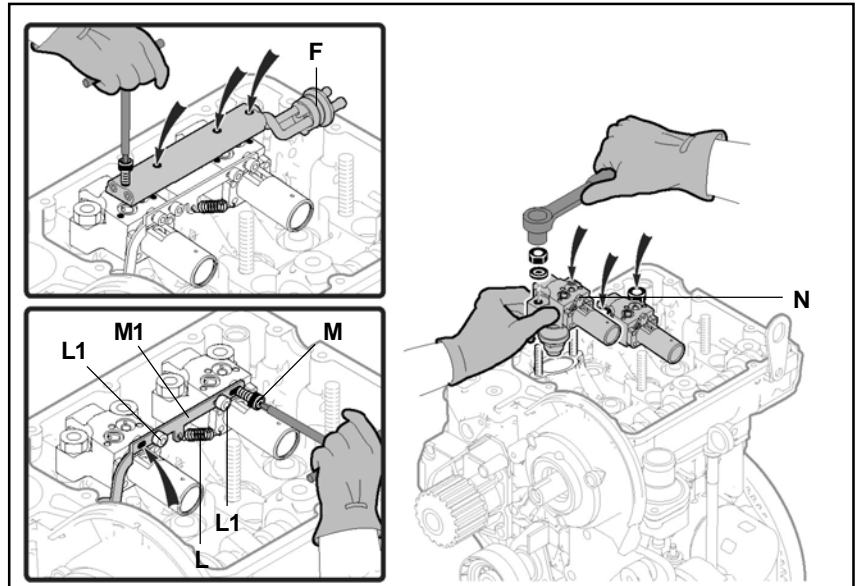
Important

If injector pumps are to be used during installation, do not loosen the screws (L1) in order to not balance injector pump deliveries during tuning.

3 - Unscrew the screws (M).

4 - Remove the connecting rod (M1).

5 - Dismount the injection-pumps (N).

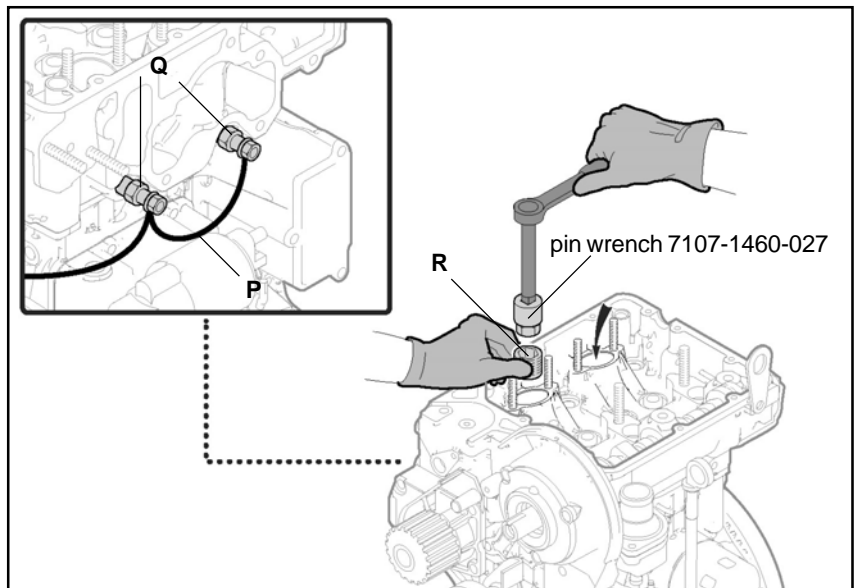


5.5.5 Disassembling precombustion chamber

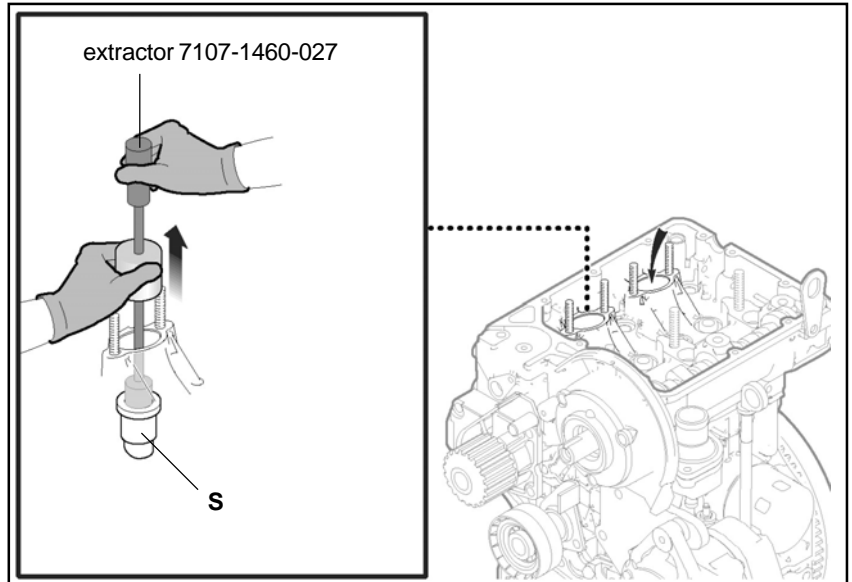
1 - Disconnect the electric cable (P).

2 - Remove the preheating glow plugs (Q).

3 - Unscrew the ring nut (R) using the special pin wrench "7107-1460-027".

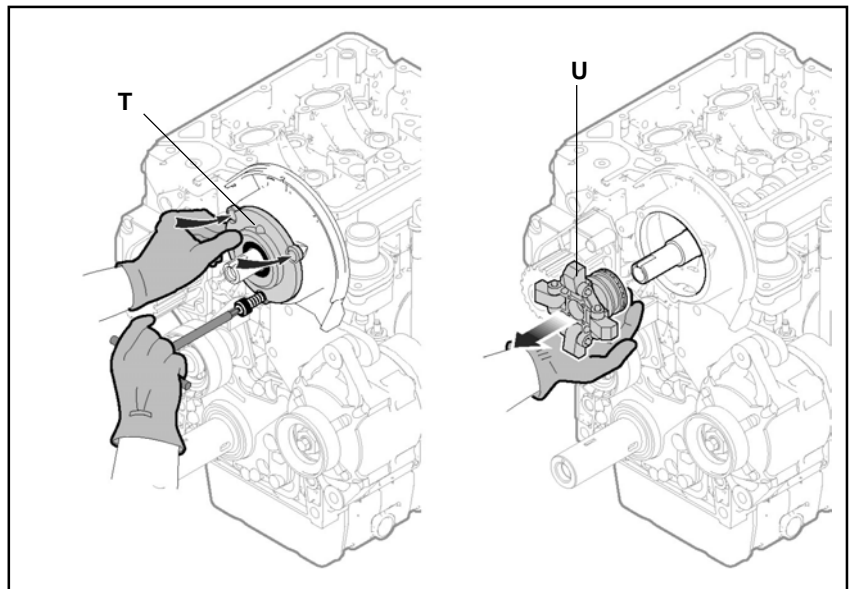


- 4 - Screw the extractor "7107-1460-030" onto the precombustion chamber (**S**) and remove it.

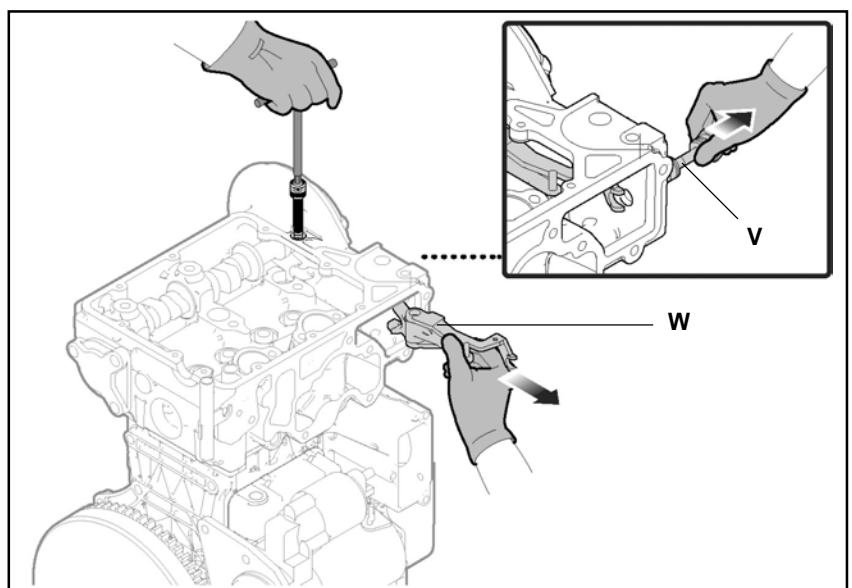


5.5.6 Disassembling the speed governor and flow limiter

- 1 - Remove the cover (**T**).
 2 - Extract the weights assembly (**U**) from the camshaft.



- 3 - Remove the fuel flow limiter (**V**).
 4 - Unscrew the pin and extract the governor linkage adjustment pin (**W**).

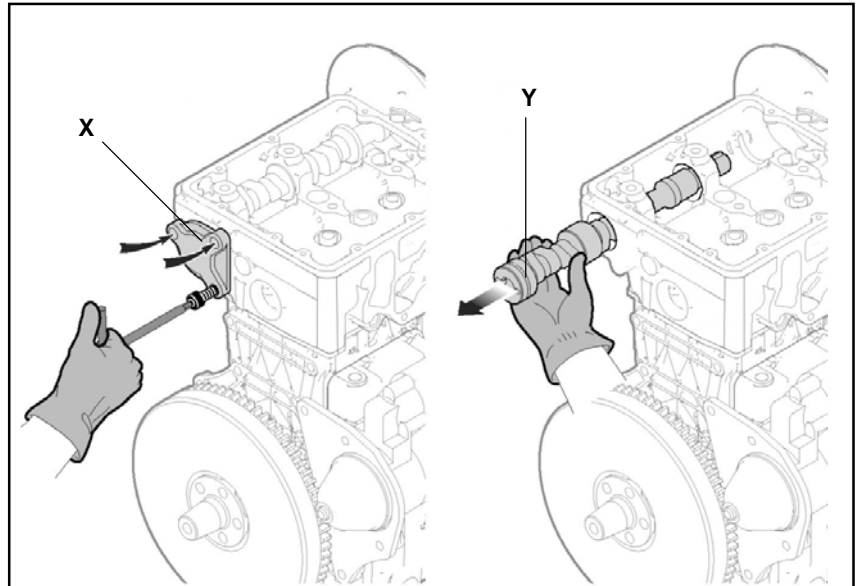


5.5.7 Disassembling the camshaft

- 1 - Remove the cover (X).
- 2 - Extract the camshaft (Y) from the cylinder head.

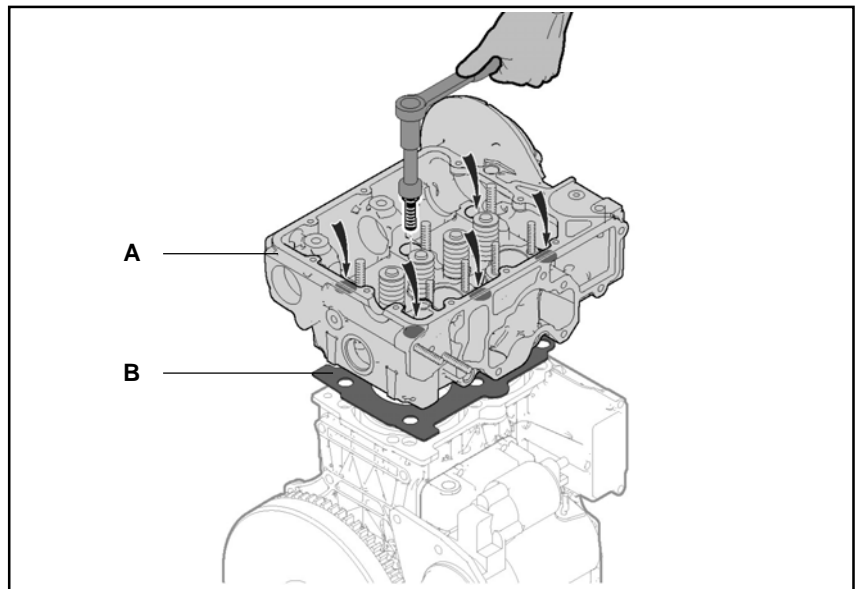


Make sure the drive rod has been removed and rotate the camshaft gently to remove it easily.



5.5.8 Disassembling the cylinder head

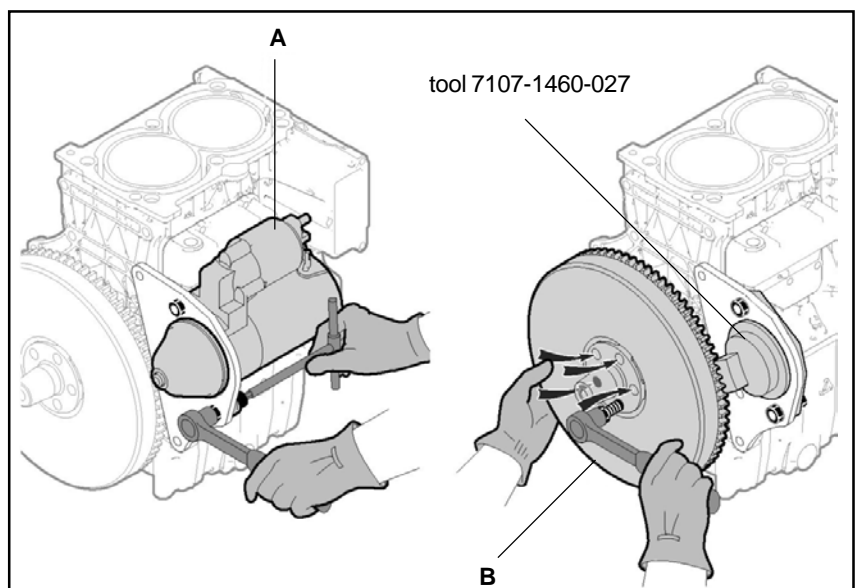
- 1 - Remove the cylinder head (A).
- 2 - Take off the gasket (B).



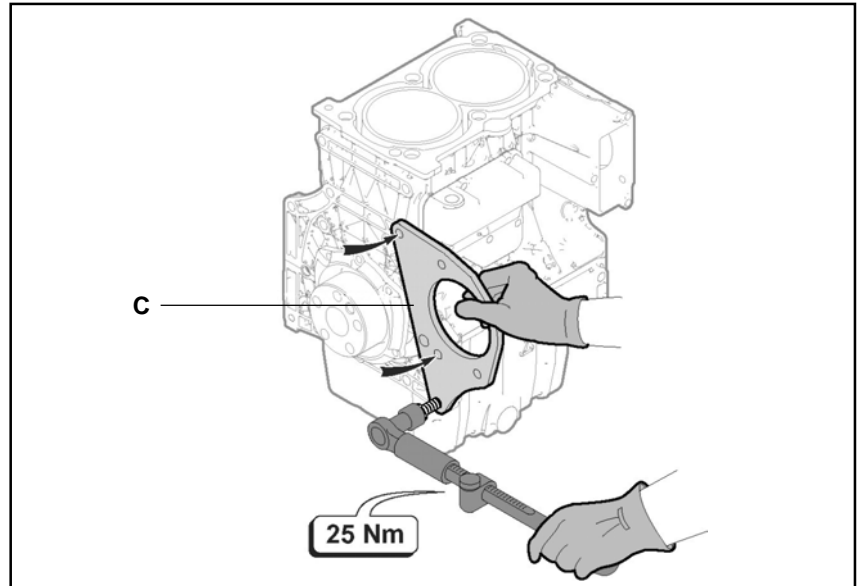
5.6 REMOVING THE CRANK GEAR AND CRANKCASE

5.6.1 Disassembling the flywheel

- 1 - Disassemble the starter motor (A).
- 2 - Install tool "7107-1460-051" to inhibit rotation of the crankshaft.
- 3 - Remove the flywheel (B).



4 - Remove the support (C).

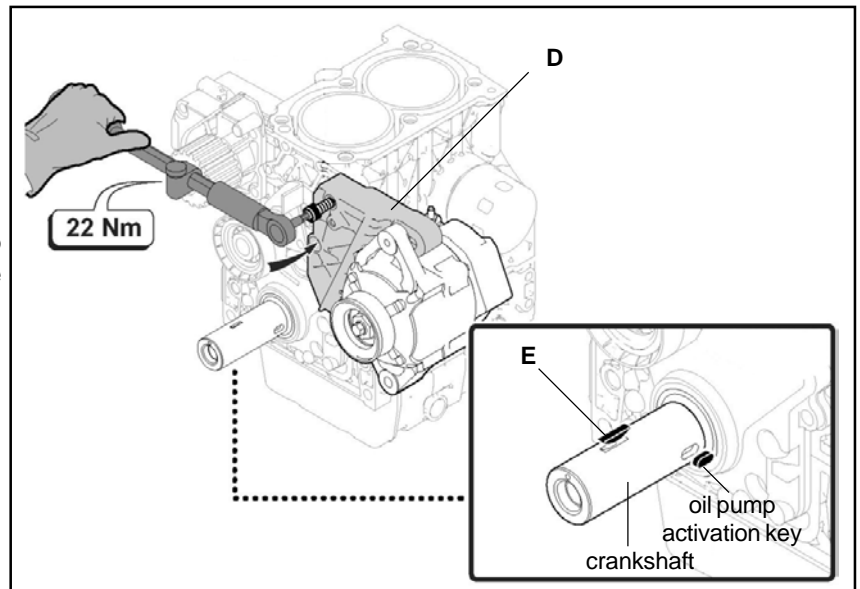


5.6.2 Disassembling the oil pump

1 - Remove the flange (D).

2 - Extract the key (E) from the crankshaft.

3 - Bring piston number one (flywheel side) to the top dead centre, with the oil pump activation key in line with break in the flange, in order to be able to remove it.

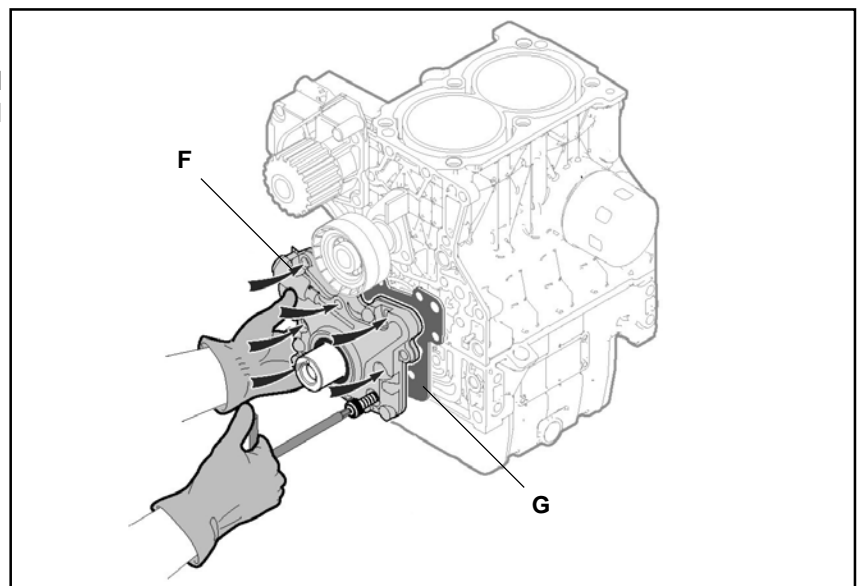


Important

You should in no way try to force removal of the pump, if its activation key is not lined up with the break in the flange.

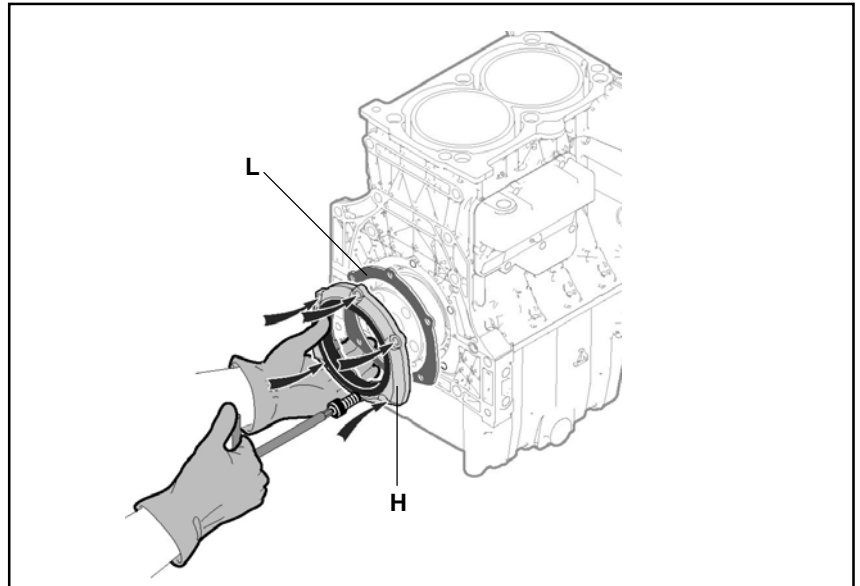
4 - Remove the oil pump (F).

5 - Take off the gasket (G).

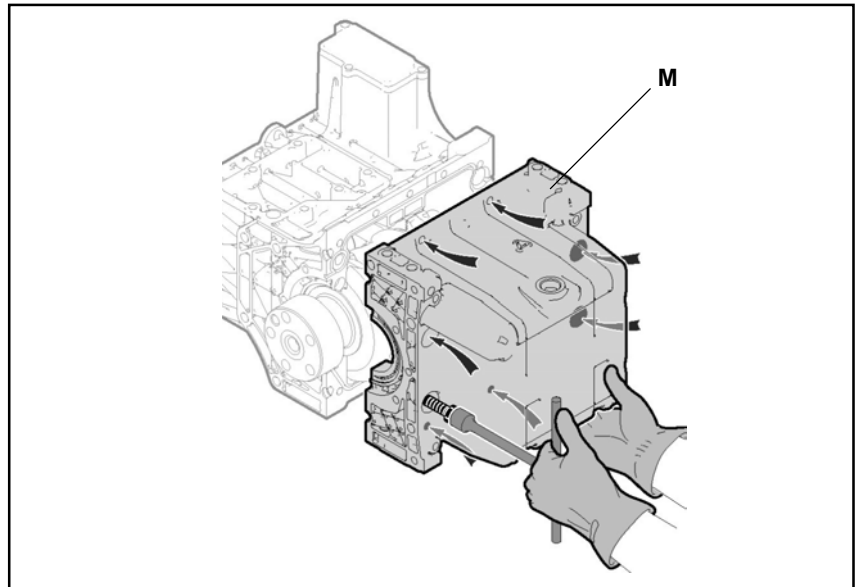


5.6.3 Disassembling the crankcase and crankshaft

- 1 - Remove the flange (H).
- 2 - Tske off the gasket (L).



- 3 - Remove the crankcase (M).



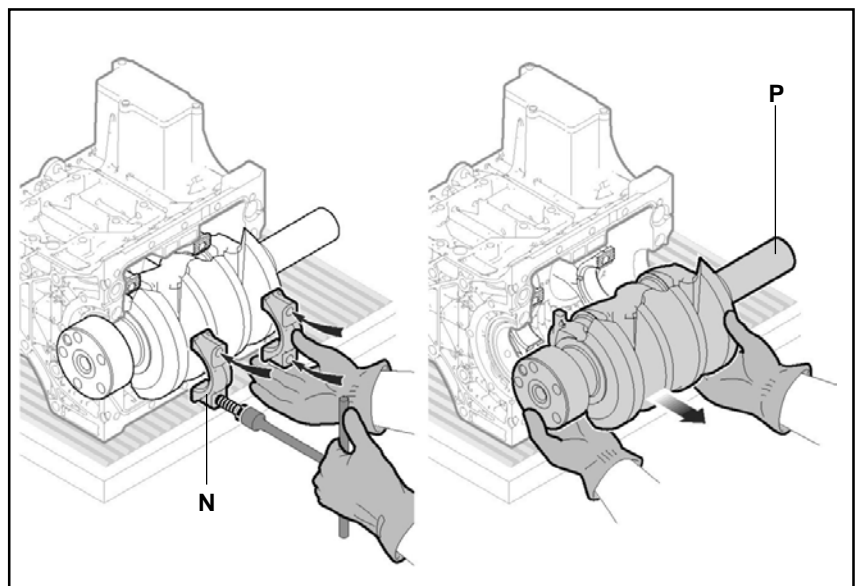
- 4 - Remove the connecting rod cap (N).



Caution - Warning

Before removing the cap, mark the area of contact with the connecting rod, in order to recognise the right position during reassembly.

- 5 - Remove the crankshaft (P) and place it in a container for washing.



5.6.4 Disassembling connecting rod and piston

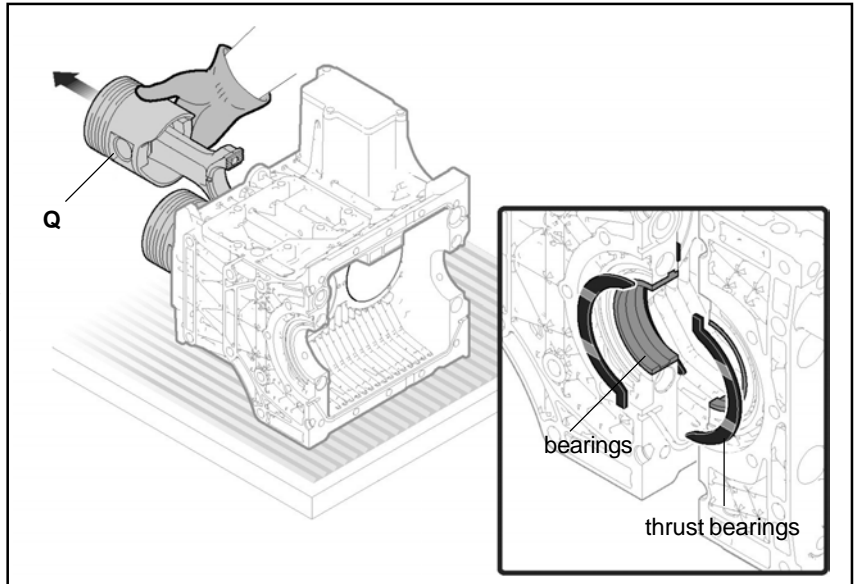
- 1 - Extract the connecting rod/piston assembly (Q).
- 2 - Remove the crankshaft half bearings.

 **Caution - Warning**

Before removing the crankshaft half bearings, mark the seat position, in order to recognise and match it up during reassembly.

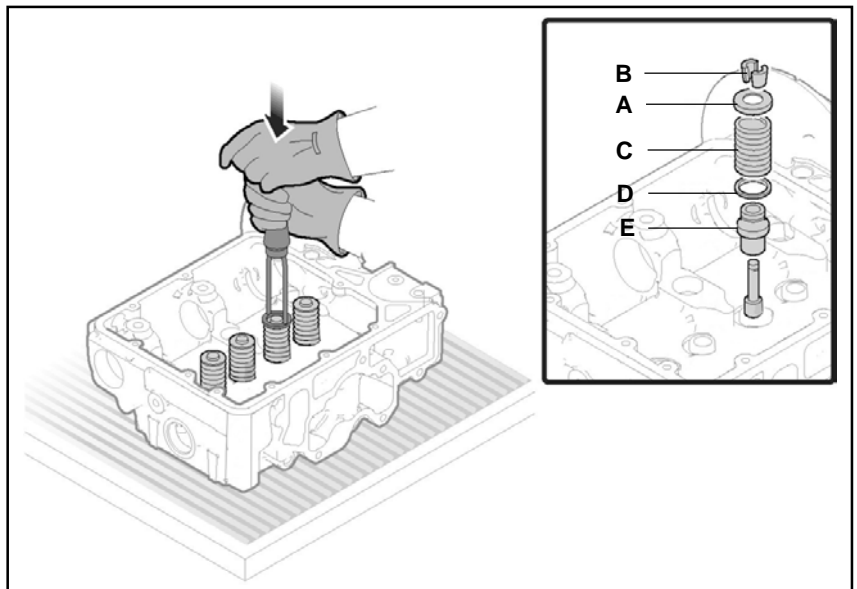
 **Important**

Be careful not to damage the half bearing during removal.



5.7 DISASSEMBLING THE VALVES

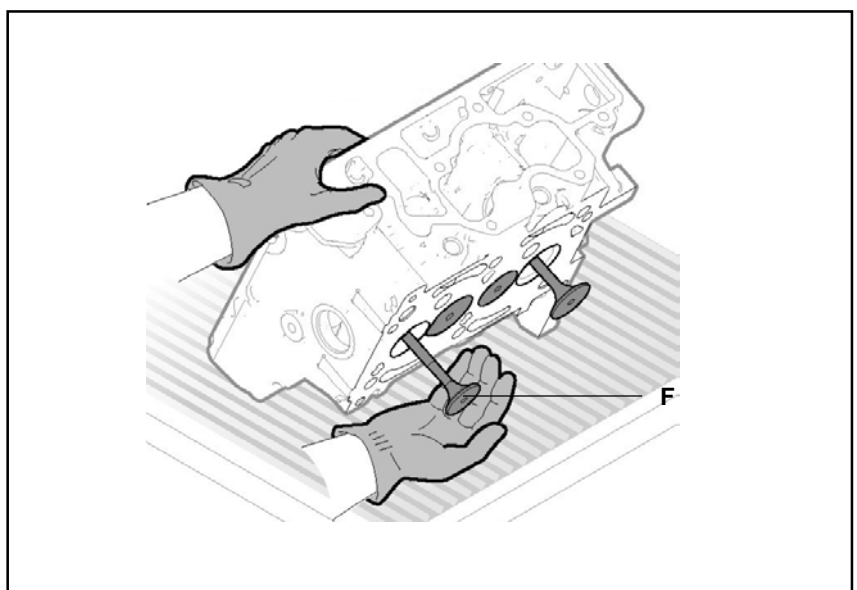
- 1 - Place the cylinder head on the workbench.
- 2 - Press down hard on the cup (A), using the special tool.
- 3 - Remove the half collets (B) blocking the cup (A), the spring (C), the collar (D) and the gasket (E).



- 4 - Remove the valves (F).

 **Important**

Keep components together during the disassembly phase, in order to be able to reassemble correctly.



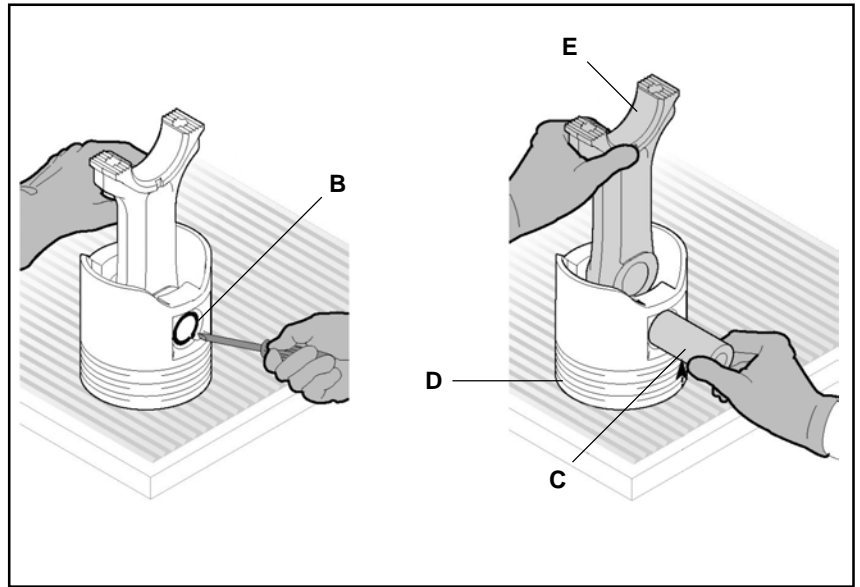
5.8 DISASSEMBLING THE PISTON

- 1 - Remove the stop ring (B).
- 2 - Extract the wrist pin (C) to separate the piston (D) from the connecting rod (E).

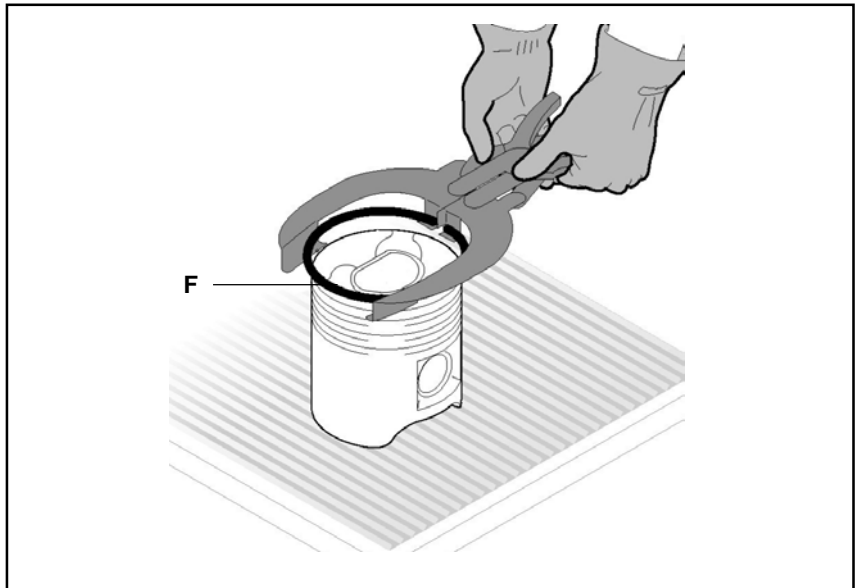


Important

Keep each connecting rod together with its piston and wrist pin.



- 3 - Remove the stop rings (F).



Notes :

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6.1 RECOMMENDATIONS FOR OVERHAULS AND TUNING

- Information is given in a logical order in terms of timing and sequence of operations. The methods have been selected, tested and approved by the manufacturer's technical experts.
 - This chapter describes procedures for controlling, overhauling and tuning assemblies and/or individual components.
-  **Important**
- To locate specific topics, the reader should refer to the index.**
- Before any intervention, the operator should lay out all equipment and tools in such a way as to enable him to carry out operations correctly and safely.
 - The operator must comply with the specific measures described in order to avoid errors that might cause damage to the engine.
 - Before carrying out any operation, clean the assemblies and/or components thoroughly and eliminate any deposits or residual material.
 - Wash the components with special detergent and do not use steam or hot water.
 - Do not use flammable products (petrol, diesel, etc.) to degrease or wash components. Use special products.
 - Dry all washed surfaces and components thoroughly with a jet of air or special cloths before reassembling them.
 - Apply a layer of lubricant over all surfaces to protect them against oxidation.
 - Check all components for intactness, wear and tear, seizure, cracks and/or faults to be sure that the engine is in good working condition.
 - Some mechanical parts must be replaced en bloc, together with their coupled parts (e.g. valve guide/valve etc.) as specified in the spare parts catalogue.

6.1.1 Shaft seals

- Clean the shaft thoroughly and make sure that it is not damaged or scored or has become oval-shaped in the areas of contact with the seals.
- Lubricate the seal lips, and pointing them in the right direction, place them in their seat using a special pad.
- Do not use a hammer directly on the gaskets during assembly, to avoid damaging them.
- Be careful not to damage the gaskets while joining them to the shaft.

6.1.2 O-Rings

- Lubricate the seal before introducing it to its seat.
- Avoid "rolling" the gasket during the attachment phase.

6.1.3 Bearings

- Use special extractors or plugs to remove bearings.
- Clean the bearings thoroughly. Check their condition and, if they are fully intact, lubricate all over, otherwise replace with original spares.
- Do not use a hammer directly on the bearings during assembly, to avoid damaging them.

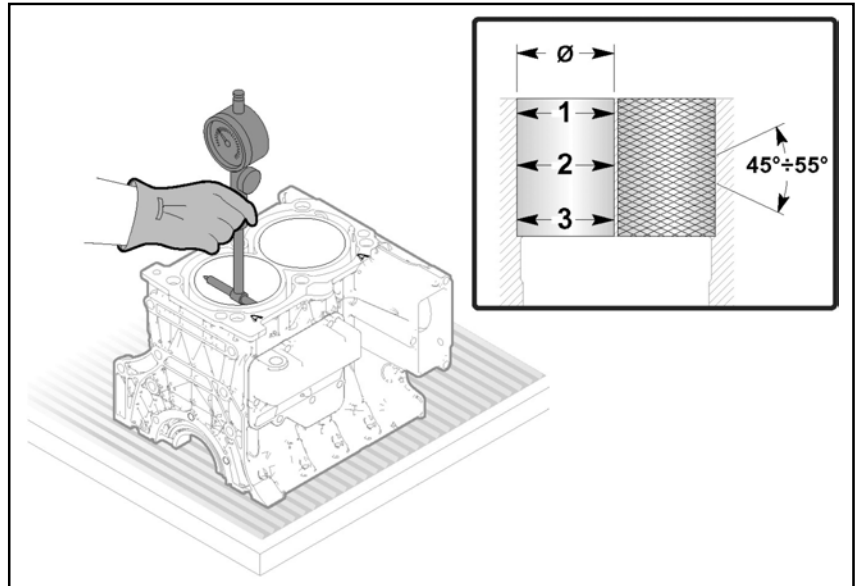
6.2 OVERHAULING THE CRANK GEARS AND CRANK CASE

6.2.1 Overhauling cylinders and pistons

Before deciding what kind of overhaul needs to be done, it is important to carry out a dimensional check and verify the correspondence of cylinders, pistons, sealing rings, crankshaft and connecting rods.

6.2.2 Dimensional check and overhaul of cylinders

- 1 - Place the engine block on the workbench.
- 2 - Using a micrometer, measure the diameter at points 1-2-3 (see diagram).
- 3 - Rotate the micrometer 90° and remeasure. If ovalization or wear is greater than 0.05mm, the cylinder must be ground .



Important

- The increases recommended by the manufacturer for the cylinder head 0.5 and 1 mm.
- When grinding make sure that the working angle is 45-55° and that the average roughness is Ra=0.5-1.
- Do not sand the internal surfaces of the cylinders using emery cloth.
- Protect the contact surfaces with lubricant oil, to prevent them from rusting

The table shows the reference values and their class (only applies to new engines).

Important

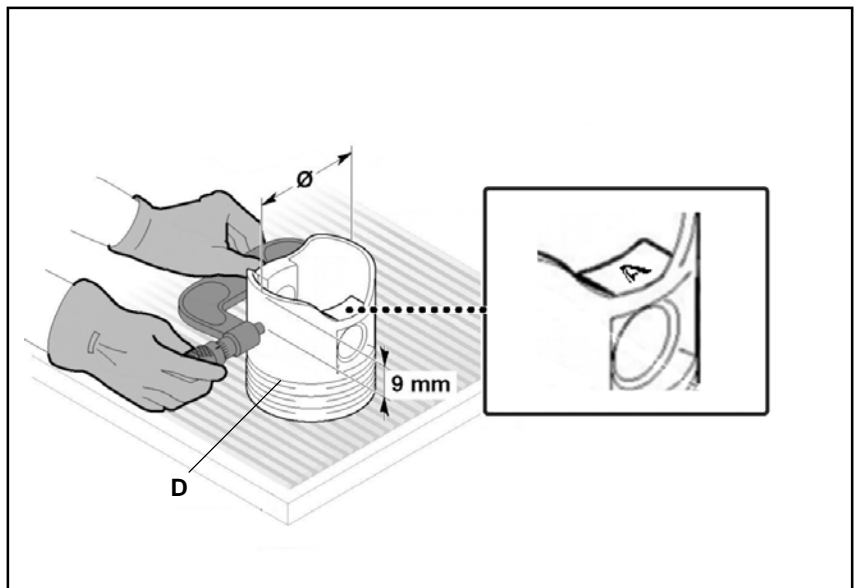
Pistons with nominal diameter are supplied only in class (A) spares. Those uprated by 0.5 and 1 mm have the uprating reference (Ø72.5 e Ø73) engraved on the upper part of the piston (see “Table of cylinder - piston classes and dimensions”).

Table of cylinder - piston classes and dimensions

Dimension class	Ø Cylinders (mm)	Ø Pistons (mm)	clearance (mm)
A	71,990÷72,000	71,930÷71,940	0,05÷0,07
B	72,000÷72,010	71,940÷71,950	
C	72,010÷72,020	71,950÷71,960	
R	72,100÷72,120	72,031÷72,049	

6.2.3 Dimensional check and overhaul of pistons

- 1 - Clean the piston thoroughly (D).
- 2 - Using a micrometer, measure the piston 9mm from the base of the skirt.
- 3 - Check the table to identify the class from the values detected. The class letter is engraved on the piston, If clearance between cylinder and piston is greater than 0.05mm, the piston and sealing rings must be replaced, and rematched according to the diameter of the ground cylinders “see Table of cylinder-piston classes and dimensions”).



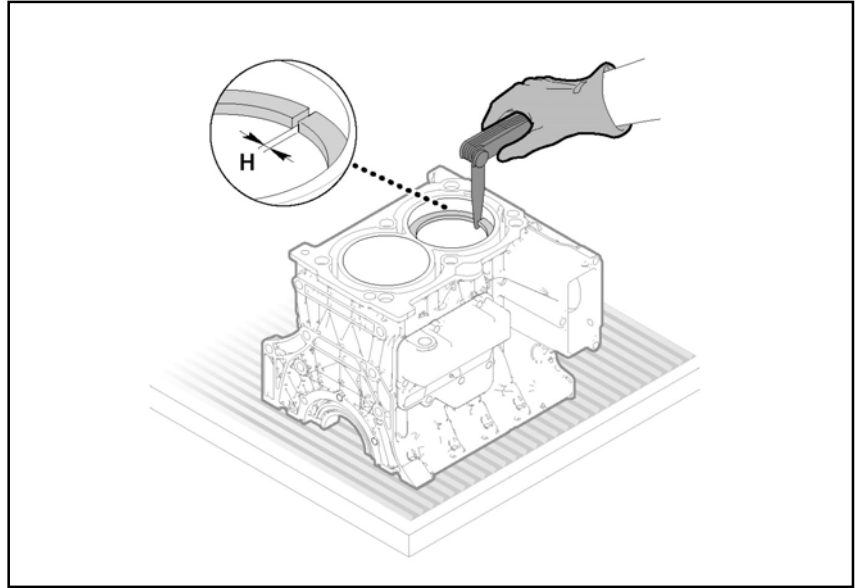
Important

Before replacing the pistons, check that the weight difference does not exceed 4g to prevent weight imbalances.

Protect the contact surfaces with lubricant oil, to prevent them from rusting.

6.2.4 Dimensional check of sealing rings

- 1 - Place a sealing ring in the cylinder and measure the distance between the two tips using a thickness gauge (**H**).
- 2 - Repeat for all the sealing rings.
If the distance between the tips does not correspond to the indicated values, replace the sealing ring with an original spare (see "Dimensional table of sealing rings").



Dimensional table of sealing rings

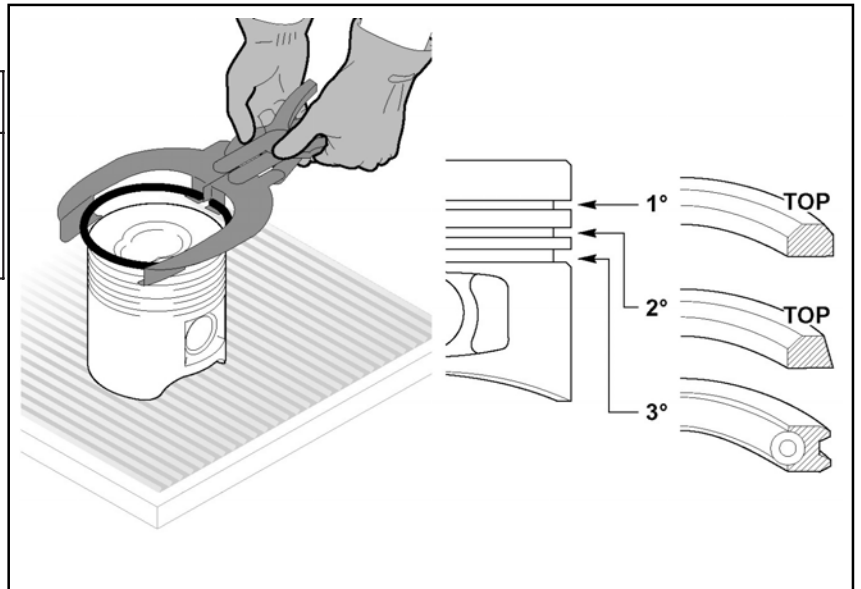
Sealing rings	distance between tips (mm)	Wear & tear limit (mm)
1°	0,25÷0,45	1,0
2°	0,25÷0,45	
3°	0,20÷0,45	

- 3 - Put the sealing rings on the piston in the order shown in the figure.



Important

Place the sealing rings with the markings facing up towards the upper part of the piston (crown).



- 4 - Using a thickness gauge, measure the clearance of each sealing ring. If clearance does not correspond to the values shown, replace the sealing rings with original spares.

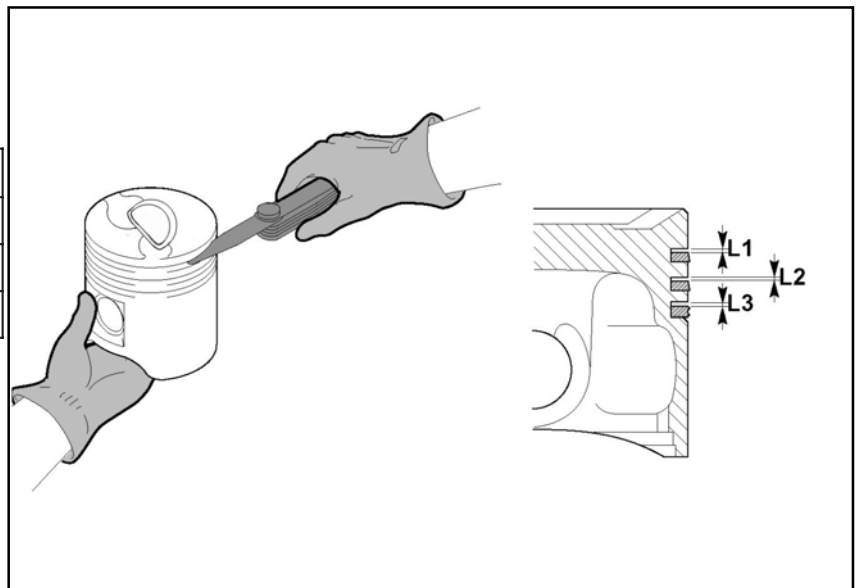
Table of sealing rings clearance

Sealing rings	Clearance (mm)
1°	L1= 0,090÷0,125
2°	L2= 0,050÷0,085
3°	L3= 0,040÷0,075



Important

- Sealing rings cannot be replaced separately.
- Protect the contact surfaces with lubricant oil, to prevent them from rusting.



6.2.5 Dimensional check and overhaul of crankshaft

- 1 - Wash the crankshaft thoroughly using suitable detergent.
- 2 - Introduce a pipe cleaner into the lubrication ducts to remove any residual dirt.
- 3 - Blow compressed air into the points indicated to free the ducts from oil.
- 4 - Check the surfaces of the main journals and crank pins for wear and tear to see whether grinding is necessary.
- 5 - Using a micrometer, measure the diameter of the main journals (**A1**) and crank pins (**B1**).
- 6 - Using a dial indicator, measure the inside diameters of the crankshaft (**A2**) and connecting rod (**B2**) half bearings .

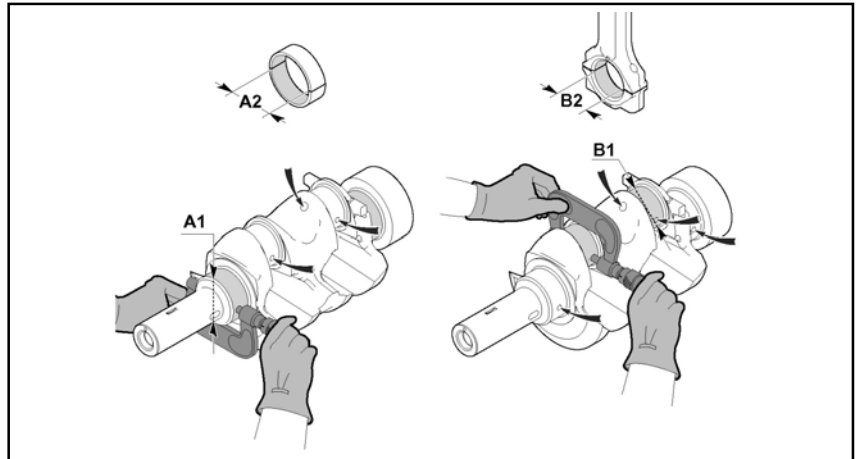


Table of diameters of connecting rods and half bearings

Ref.	Dimensions (mm)	Wear & tear limit (mm)	Clearance (mm)	wear & tear lim (mm)
A 1	47,984÷48,000	47,900	A 2-A 1=0,032±0,016	0,200
A 2	48,022÷48,058	48,055		
B 1	39,894÷40,000	39,900	B 2-B 1=0,021±0,066	0,130
B 2	40,020÷40,035	40,100		

Table of diameters of connecting rods and half bearings PROGRESS

Réf.	Dimensions (mm)	Wear and tear limit (mm)	Clearance (mm)	Max clear. (mm)
A 1	47,984÷48,000	47,95	A 2-A 1=0,025±0,087	0,12
A 2	48,025÷48,071	48,1		
B 1	39,984÷40,000	39,95	B 2-B 1=0,021±0,066	0,10
B 2	40,021÷40,05	40,08		

Table of uprated shoulder half-rings

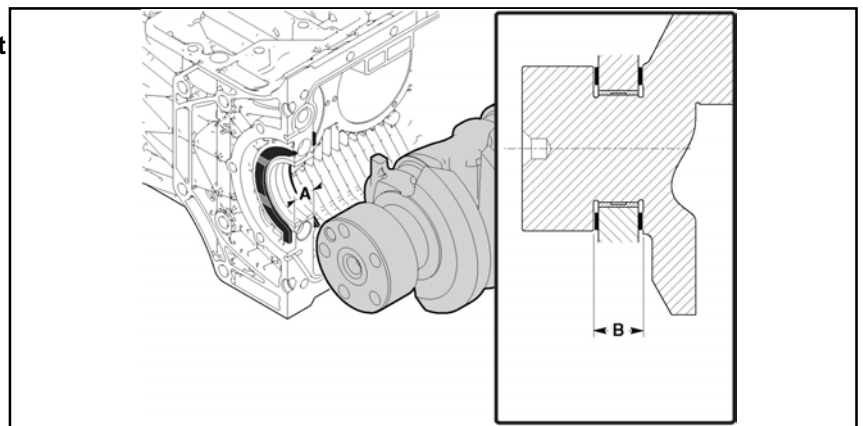
Half-rings	Dimensions (mm)		
	A	B	Clearance
Standard	22,787÷22,920	23,050÷23,100	C = A - B 0,130±0,313
1° increase	22,987÷23,120	23,250÷23,300	
2° increase	23,087÷23,220	23,350÷23,400	
3° increase	23,187÷23,320	23,450÷23,500	

Important

- Crankshaft half bearings cannot be replaced separately.
- If the crankshaft needs to be ground, establish the diameters of the connecting rod and crank pins, in order to choose the matching measurements available of connecting rod and half bearing spare parts (see “Table of diameters of connecting rods and half bearings”).
- When grinding the crankshaft it is possible to downrate the crankshaft and connecting rod pins by 0,25 mm and 0,50 mm.
- When grinding the crankshaft it is also necessary to consider grinding the sides (shoulder) to be able to choose uprated ring replacements (see “Table of uprated shoulder half-rings”).

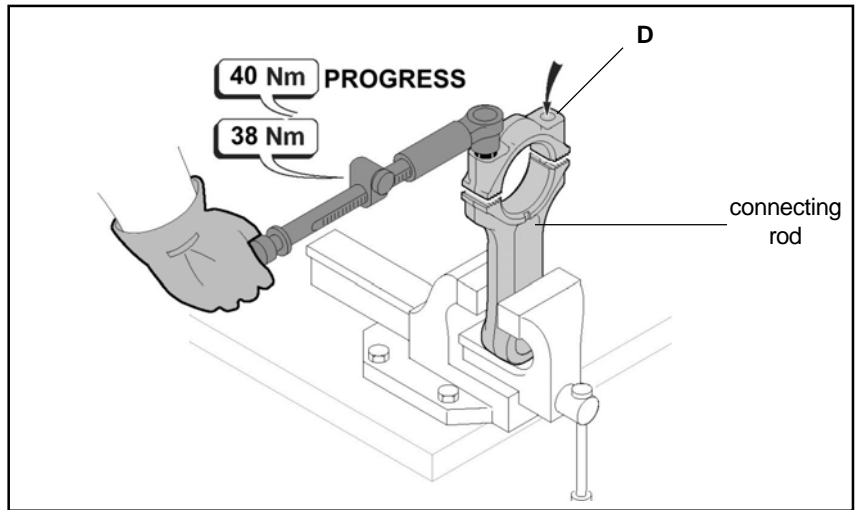
Important

Protect the contact surfaces with lubricant oil, to prevent them from rusting.



6.2.6 Dimensional check and overhaul of connecting rods

- 1 - Check that the contact surfaces are perfectly clean and intact.
- 2 - Assemble the cap (D) onto the connecting rod big end and tighten the screws to a torque of 38 Nm (40 Nm x PROGRESS).
- 3 - Using a micrometer, measure diameters $\varnothing a-b$.



Important

- If the diameter of the connecting rod small end does not match the diameter of the wrist pin, the connecting rods must be replaced to achieve the right match (see "Table of connecting rod dimensions").
- The half-bearings are supplied smaller than the nominal dimensions, by 0,25 mm and 0,50 mm.
- Before replacing the connecting rods, check that the weight difference does not exceed 10g to prevent weight imbalances (see "Table of connecting rod dimensions").
- Protect the contact surfaces with lubricant oil, to prevent them from rusting.

Table of connecting rod dimensions

Ref.	Dimensions	Clearance (mm)	wear & tear limit (mm)
d	109,975±110,025	$\varnothing b - \varnothing c$ 0,010±0,025	0,40
$\varnothing b$	20,010±20,020		
$\varnothing c$	19,995±20,000		
$\varnothing a$	40,020±40,035		
e	55,000±55,020		

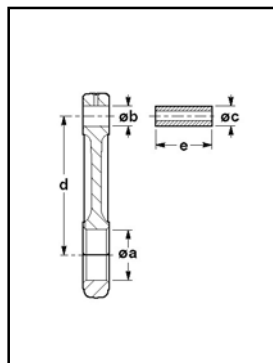
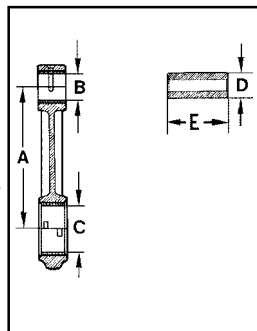


Table of connecting rod dimensions PROGRESS

Réf.	Dimensions (mm)	Clearance (mm)	Wear and tear limit (mm)
A	106,98±107,02	B-D 0,015±0,03	0,06
B	18,015±18,025		
D	17,995±18		
C	40,021±40,05		
E	50,9±51,1		

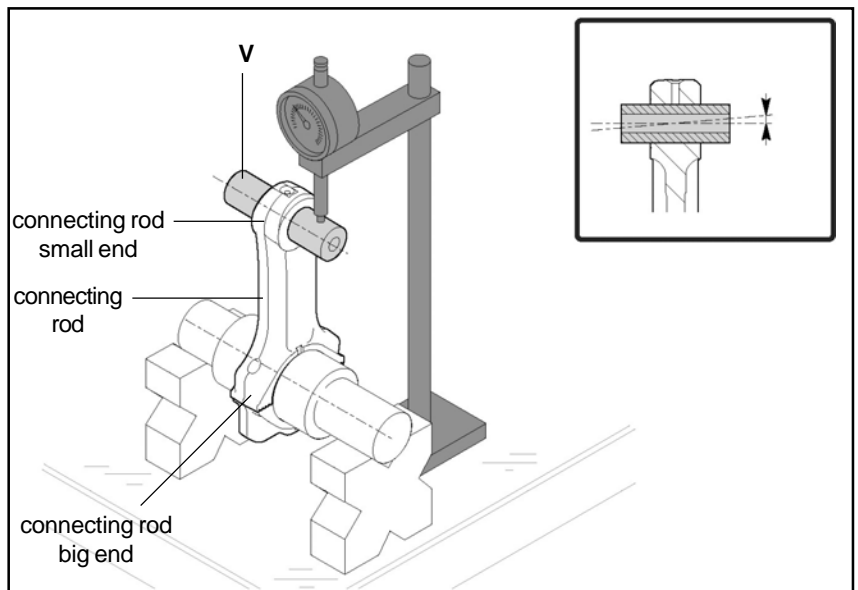


6.2.7 Checking parallelism of the connecting rod axes

- 1 - Insert the wrist pin (V) in the connecting rod small end.
- 2 - Use a dial indicator to check that there is parallelism between the small end and big end axes. Parallel deviation, measured at the very tip of the wrist pin, must not exceed 0.015-0.030mm. If parallel values do not correspond to those indicated, replace the connecting rod with an original spare.
- 3 - After carrying out all checks and overhauls, remount the connecting rods, pistons and sealing rings (see "Pre-assembly of sealing rings - pistons" and "Pre-assembly of connecting rods - pistons").

Important

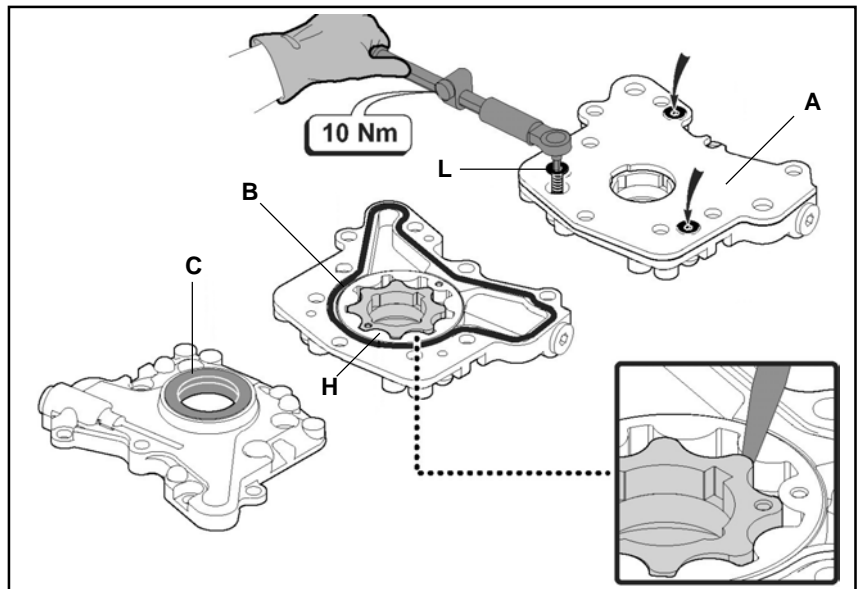
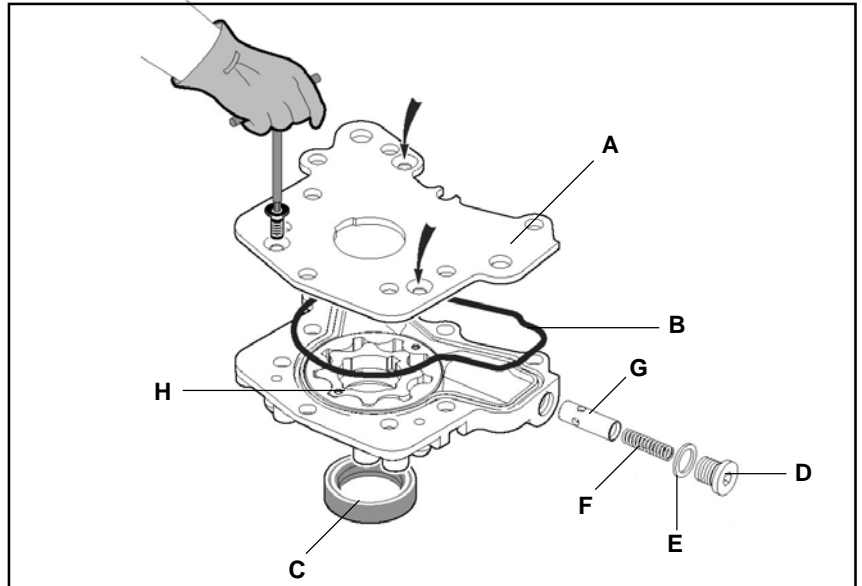
Protect the contact surfaces with lubricant oil, to prevent them from rusting.



6.2.8 Check and overhaul of the fuel pump

Disassemble the oil pump before checking or overhauling. See "Disassembling the oil pump" for the correct procedure.

- 1 - Remove the plate (A).
- 2 - Remove the O-ring (B).
- 3 - Remove the sealing ring (C) from the flange and clean the seat.
- 4 - Unscrew the oil (D) and extract the gasket (E), the spring (F) and the valve (G).
- 5 - Disassemble the rotors (H).
- 6 - Blow compressed air into the valve seat to clean it.
- 7 - Thoroughly clean all the components.
- 8 - Measure the length of the spring (F). If the length of the spring is not between 27.50 and 27.75mm, replace it with an original spare.
- 9 - Replace the valve (G), the spring (F), the gasket (E) and the plug (D).
- 10 - Fill the sealing ring (C) with grease and lubricate the rim with oil.
- 11 - Mount the new sealing ring (C) using a special tool.



Important

Given the particular function played by this sealing ring, it is important to use only original spares.

- 12 - Mount the rotors (H) with the reference notches facing upwards so that they are visible.
- 13 - Using a thickness gauge, measure the clearance between the rotor teeth.
If clearance is above the 0.25mm limit for wear, replace the rotors with original spares.
- 14 - Check that the contact surfaces are perfectly clean, intact and not deformed.
- 15 - Mount the new O-ring.

Important

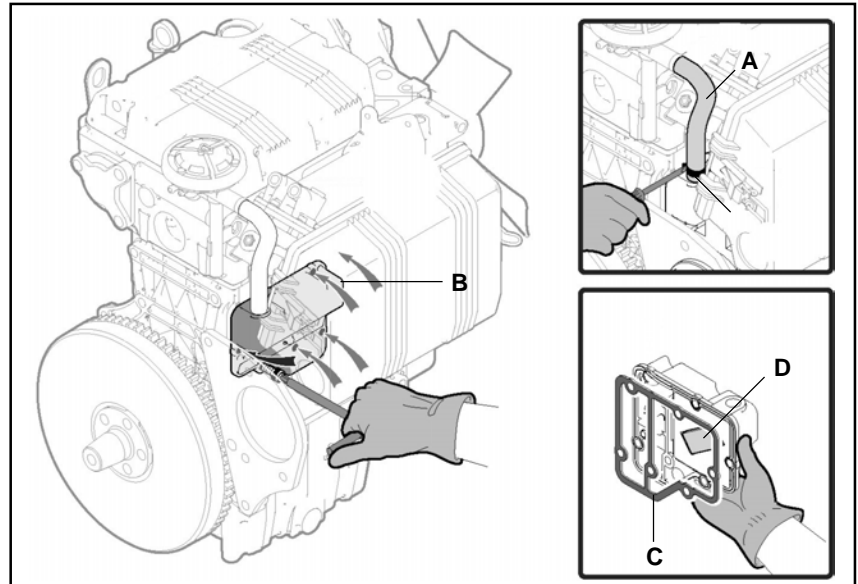
The O-ring must always be replaced with an original spare part whenever the pump is disassembled.

- 16 - Replace the plate (A) and put in the screws (L).
- 17 - Tighten the screws (L) to a torque of 10 Nm.

6.2.9 Overhauling the decanting device

In order to overhaul the decanting device, it is necessary to disassemble the starter motor. See "Replacing the starter motor" for the correct procedure.

- 1 - Loosen the clamp and extract the pipe (A).
- 2 - Remove the cover (B).
- 3 - Thoroughly clean the inside of the cover and blow compressed air on the decanting device (C) to eliminate residues.
- 4 - Check that the decanting device is intact and, if necessary, replace it with an original spare.
- 5 - Slip on a new gasket (D).
- 6 - Replace the cover (B) and fix it using the screws.
- 7 - Replace the pipe (A) and fasten it using the clamp.
- 8 - Mount the starter motor and tighten the screws to a torque 45 Nm.



6.3 OVERHAUL OF CYLINDER HEAD AND RELATED COMPONENTS

6.3.1 Checking and overhauling the cylinder head

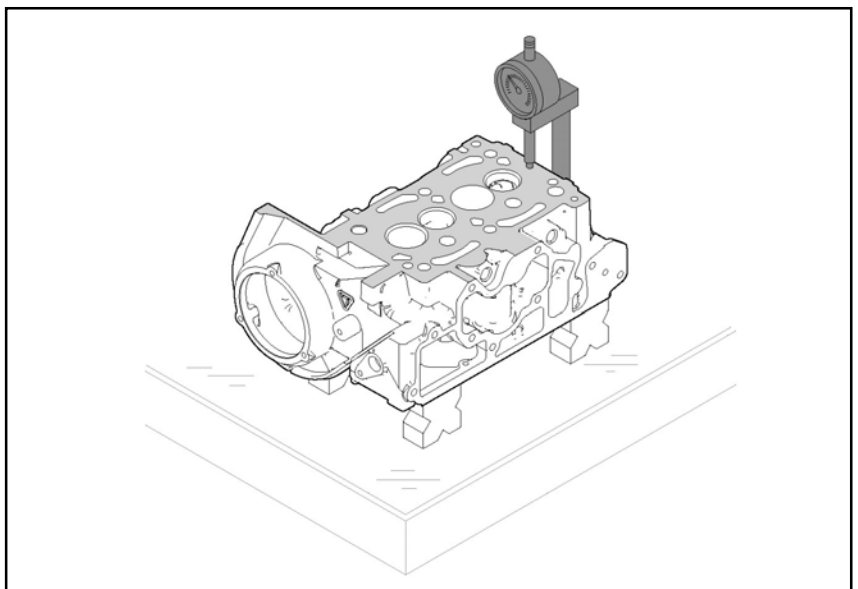
- 1 - Place the cylinder head on a surface plate and position it with the corners on the stud bolts.
- 2 - Using a dial indicator make sure the cylinder head is level.



Important

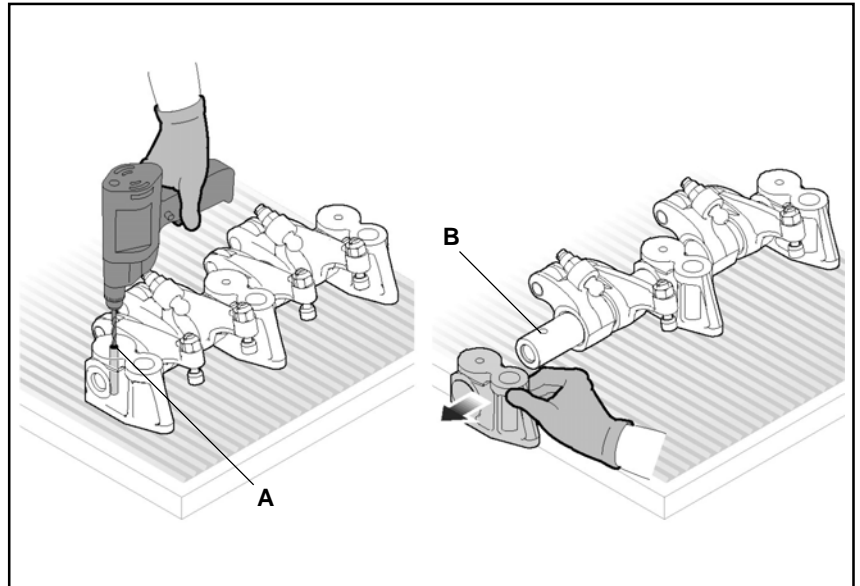
If the level deviation is above 0.1mm, the cylinder head must be ground, removing not more than 0.2mm.

- 3 - Before grinding, remove the valves (see "Disassembling the valves") and the precombustion chambers (see "Disassembling the precombustion chamber").



6.3.2 Checking and overhauling the rocker arm pin

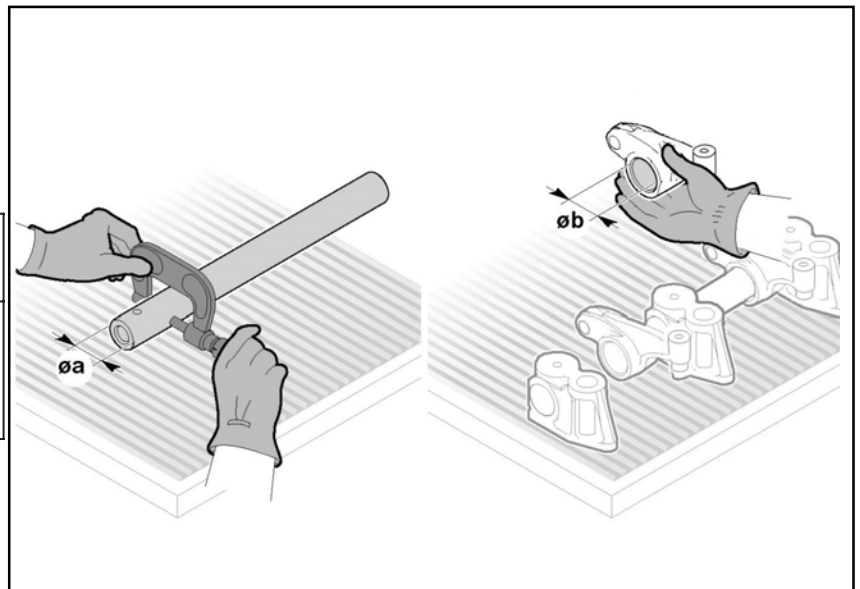
- 1 - In order to carry out a control of the rocker arm assembly, it is necessary to disassemble the cylinder head. See "Disassembling the rocker arms" for the correct procedure.
- 2 - Bore a hole in the blocking pin (A), using a 4mm bit to remove it.
- 3 - Extract the supports and the rocker arm from the pivot pin (B).
- 4 - Thoroughly clean the components.



- 5 - Using a micrometer measure, the diameters of the pivot pin and the rocker arms (see "Table of dimensions pin-rocker arm").

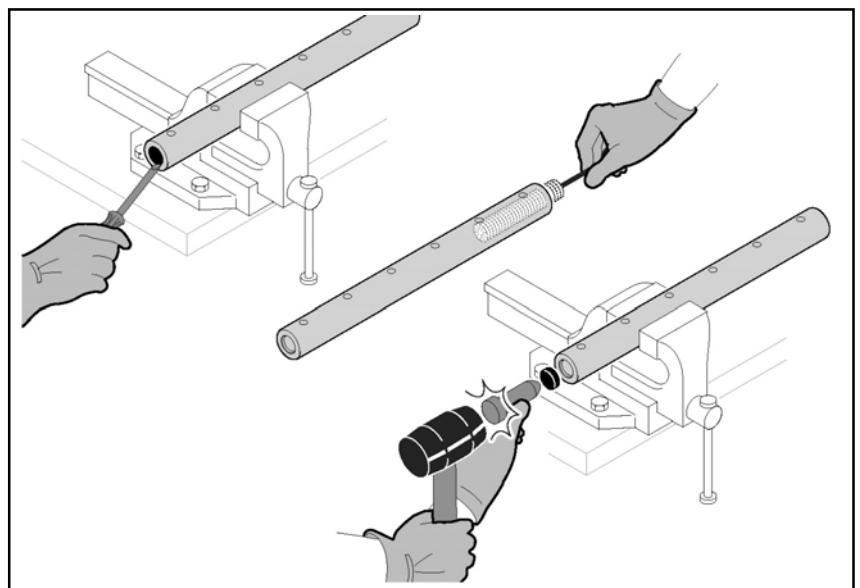
Table of dimensions pin-rocker arm

Ref.	Dimensions	Clearance (mm)	Tear & wear limit (mm)
Ø a	17,989÷18,000	Ø a-Ø b= 0,015÷0,041	0,090
Ø b	18,015÷18,030		

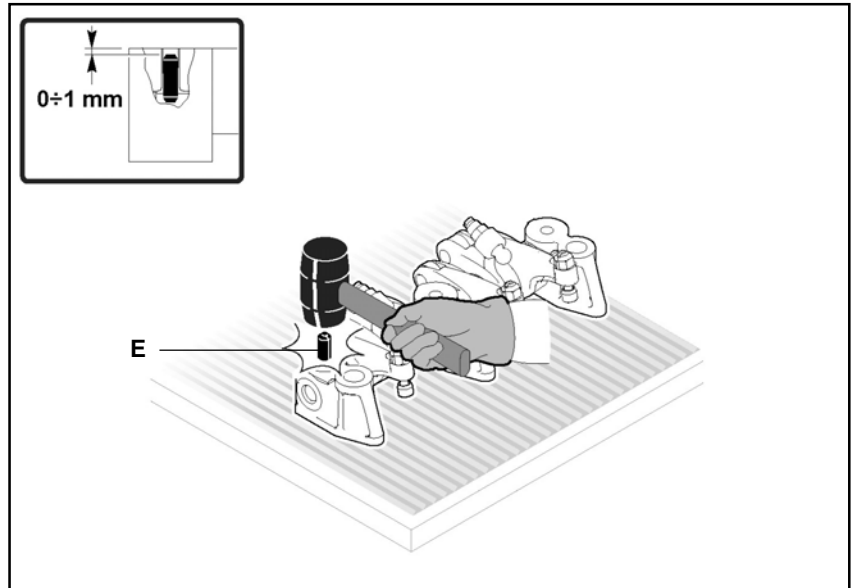


If the diameters do not correspond to the values shown, replace the pin and, if necessary, the rocker arms with original spares.
If the pin can be re-used, remove the plugs and clean the inside carefully, to eliminate residual dirt.

- 6 - Place the new plugs in the pin.
- 7 - Carefully clean and lubricate the supports and rocker arms and remount on the pin.



- 8 - Insert a new pin (E) and drive it in 0÷1 mm from the flat part of the support.
- 9 - Reassemble the rocker arm assembly in the cylinder head (see "Assembling the rocker arms").



6.3.3 Checking and replacing the camshaft

In order to carry out a control of the camshaft, it is necessary to disassemble it from the cylinder head. See "Disassembling the camshaft" for the correct procedure.

- 1 - Using a dial indicator, measure the diameters of the seats ($\varnothing X$) and, with a micrometer, find out the diameters of the camshaft ($\varnothing Y$) (see "Table of camshaft dimensions").

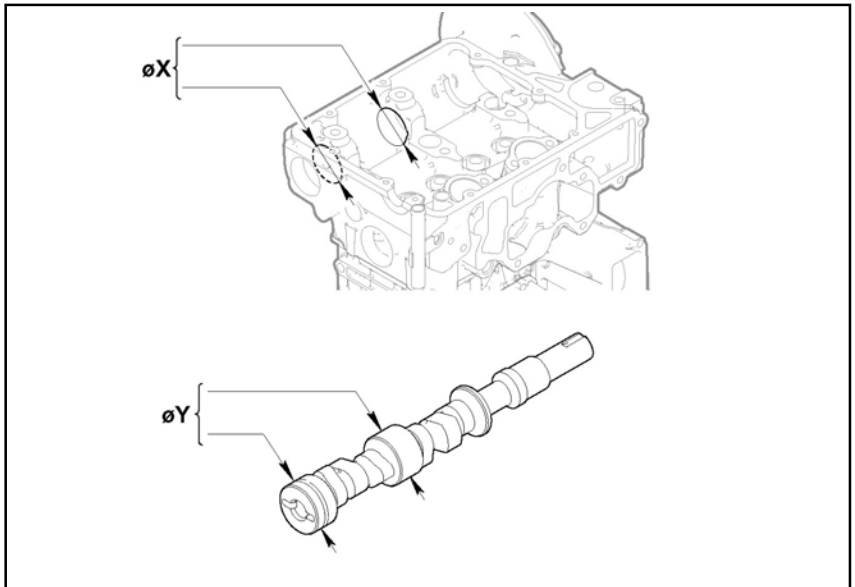


Table of camshaft dimensions

Ref.	Dimensions	Clearance (mm)	Tear & wear limit (mm)
$\varnothing a$	37,035÷37,060	$\varnothing a - \varnothing b =$	0,170
$\varnothing b$	36,975÷37,000		

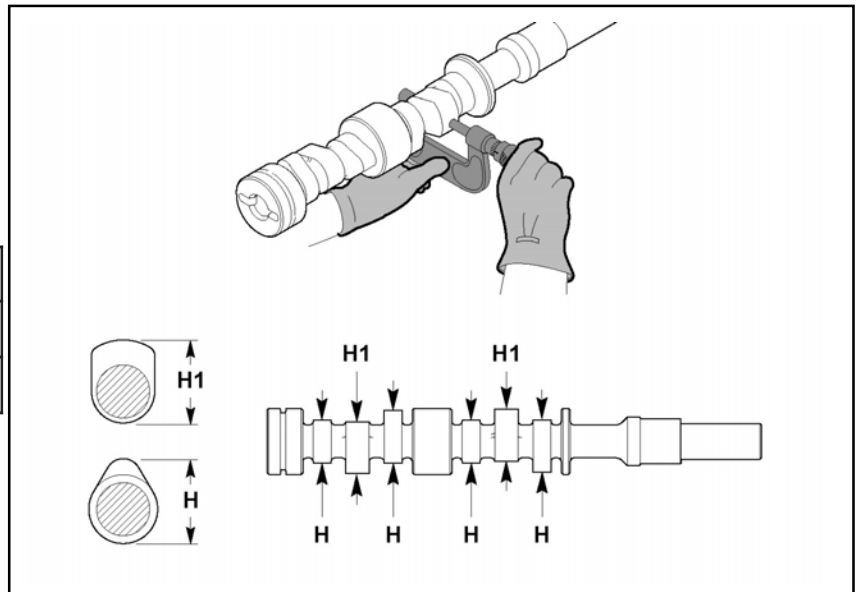
If the diameters do not correspond to the values shown, replace the camshaft with an original spare.

2 - Use a micrometer to measure the maximum dimensions of the involutes of the intake, exhaust and injection cams (see "Table of cam dimensions").

Table of cam dimensions

Ref.	Dimensions (mm)
H	29,598÷29,650
H 1	28,948÷29,000

If the dimensions of cam involutes are lower than the values shown by 0.1mm (maximum dimension), replace the camshaft with an original spare.



Important

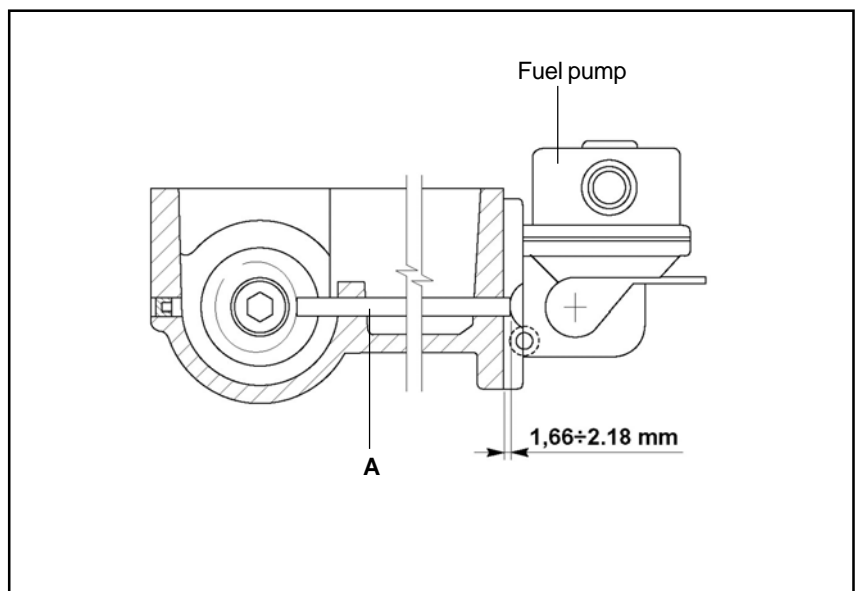
Protect the contact surfaces with lubricant oil, to prevent them from rusting.

3 - Replace the camshaft (see "Assembling the camshaft").

6.3.4 Checking and replacing the fuel pump drive rod

To check the drive rod it is necessary to disassemble the fuel pump. See "Disassembling the fuel pump" for the correct procedure.

- 1 - Rotate the camshaft until the drive rod is at the most indented point.
- 2 - Check that the distance between the drive rod (A) and the cylinder head is between 1.66 and 2.18mm. If the distance does not correspond to this value, replace the drive rod with an original spare.
- 3 - Assemble the fuel pump (see "Assembling the fuel pump").



6.3.5 Checking and overhauling the valves

In order to carry out a control of the valves, it is necessary to remove them from the cylinder head. See "Disassembling the valves" for the correct procedure.

1 - Use a gauge to measure the length of the springs (see "Table of dimensions for springs – valve stems – valve guides").

Table of dimensions for springs - valve stems - valve guides

Ref.	Dimensions (mm)	Clearance (mm)	Wear & tear limit (mm)
Ø x	7,005÷7,020	Ø b-Ø c 0,05÷0,005	0,10
Ø y	6,960÷6,990		
Z	43,5÷46,0		
W	0,5÷0,8		1,1
J	1,6÷1,7		2,0

If the length does not correspond to the value shown, replace the springs with original spares.

2 - Use a micrometer to measure the diameters of the valve stems and guides (see "Table of dimensions for springs – valve stems – valve guides"). If the diameters do not correspond to the values show, replace the valves and guides with original spares.



Important

Take measurements in several places in order to discover possible ovalization and/or wear.

3 - Thoroughly clean the valves and their seats.

4 - Measure the width of the seal for each valve (**J**) and the indentation (**W**) from the flat part of the cylinder head (see "Table of dimensions for springs – valve stems – valve guides"). If the dimensions do not correspond to the values shown, replace the valve seat ring with an original spare.

5 - Use a pointed tool to take out the valve seats.

6 - Remove any debris, clean the valve seat holder carefully and scrape the mouth.

7 - Lubricate the new valve seats and put them into the holder manually.

8 - Use the special tool to put the valve seats in the holder.

9 - Slide the valves into their seats.

10 - Measure the degree of indentation of each valve from the flat part of the cylinder head (see "Table of dimensions for springs – valve stems – valve guides").

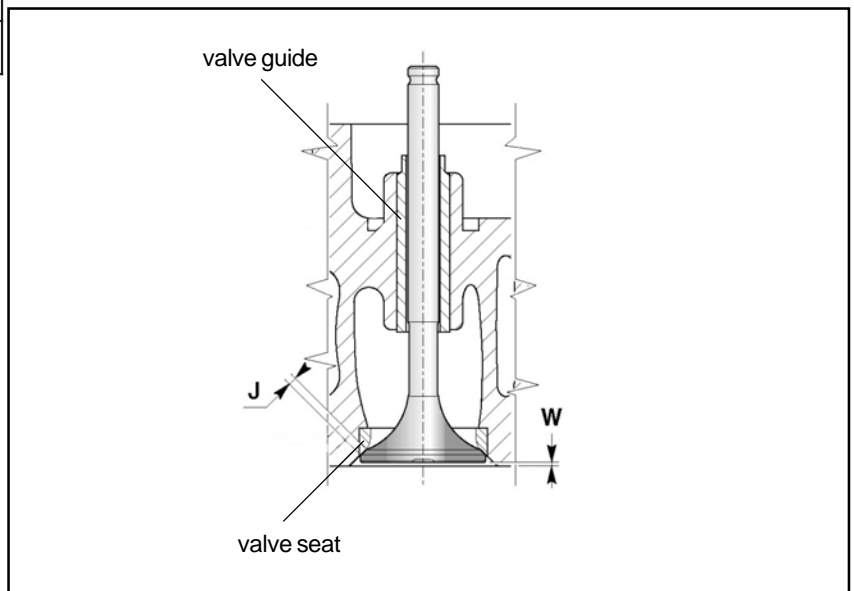
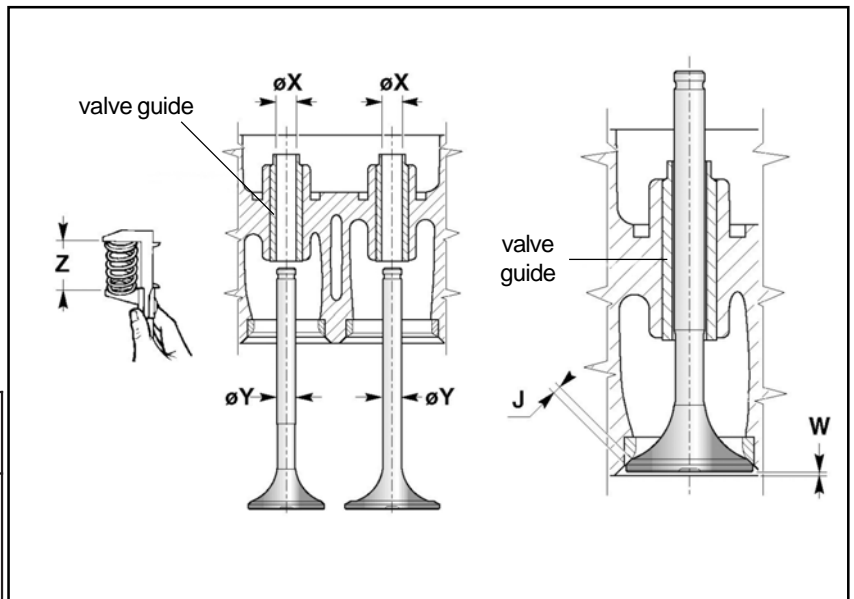
Se le dimensioni rilevate corrispondono ai valori indicati, smerigliare ogni valvola nella propria sede.



Important

Protect the contact surfaces with lubricant oil, to prevent them from rusting.

11 - Assemble the valves (see "Assembling the flywheel").



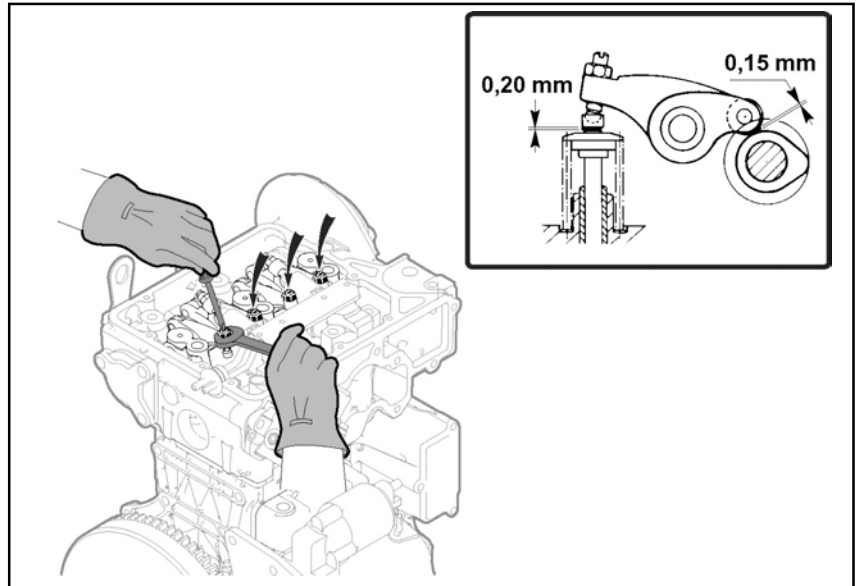
6.3.6 Adjusting valve-rocker arm clearance

In order to make the adjustment, it is necessary to remove the rocker arm cover. See "Disassembling the rocker arm cover" for the correct procedure.

Important

Adjustment of valve clearance must be done when the engine is cold.

- 1 - Place the pistons at the compression top dead centre.
- 2 - Turn the screw and the lock nut to adjust clearance. Adjustment can be made in two different points: the contact area between the rocker arm and the camshaft (0.15mm) and/or the contact area between the rocker arm and the valve (0.2mm).
- 3 - Repeat the same operation on the other valves.



6.3.7 Checking clearance volume

- 1 - Position the pistons at the top dead centre.
- 2 - Measure the distance in four diametrically opposite points on the piston crown.
- 3 - Repeat the operation on all pistons. The maximum value determines the measurement (A).

Choose the gasket corresponding to the measured value. This match determines the value of the clearance volume (see "Table of head gasket and clearance volume values").

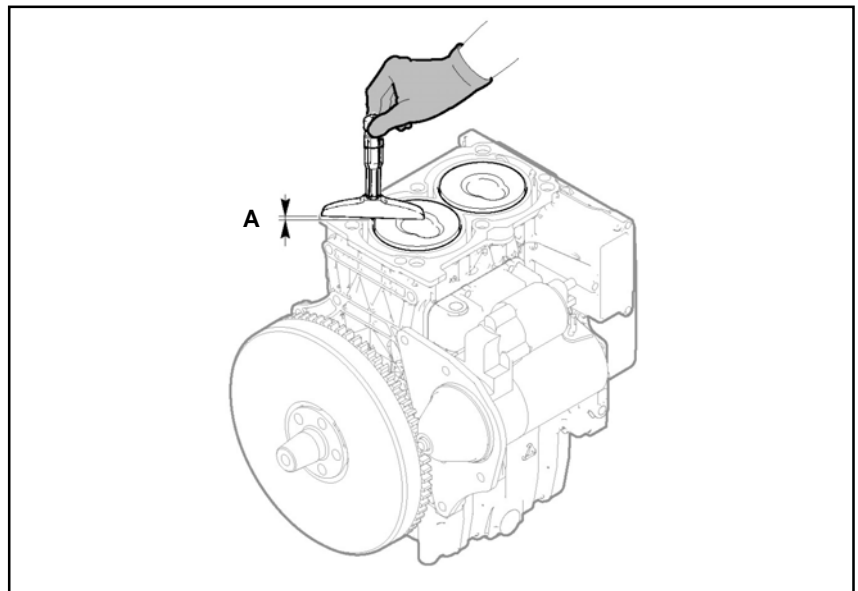


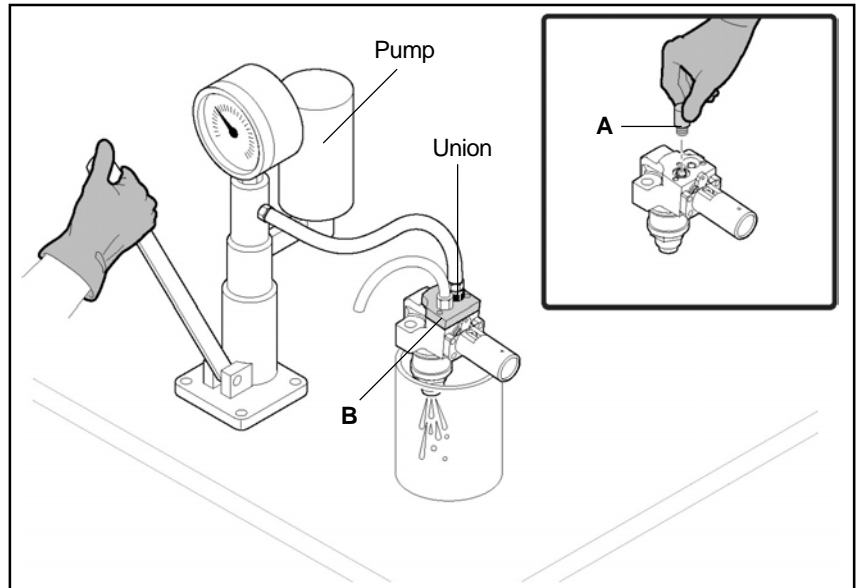
Table of head gasket and clearance volume values

A (mm)	Number of holes		Clearance volume (mm)
0,97÷1,06	0		0,39÷0,48
1,07÷1,16	1		
1,17÷1,25	2		0,40÷0,48

6.3.8 Calibrating the injector

To carry out setting, the injector pump must be disassembled from the engine.
Per conoscere la procedura corretta, vedi "Smontaggio pompe-iniettori".

- 1 - Remove the non-return valve **(A)** and replace it with the plug supplied with the "7107-1460-074" tool.
- 2 - Mount the tool head **(B)** and fasten with the screws.
- 3 - Connect the pump for calibrating the diesel injectors to the head union.
- 4 - Press the pump and bring to a pressure of 130 bars for 10 sec, in order to check the needle seal. Replace the nozzle (see "Nozzle-injector replacement") if there is any dripping.
- 5 - Press the pump again and check to see whether the fuel comes out at a pressure of 140-155 bars (optimal operating calibration).
- 6 - If calibration is not optimal, it is possible to modify the action of spring, using the adjustment shims. The adjustment shims are available in 11 sizes between 1mm and 2mm, uprated at 0.1mm gaps. If after inserting the largest adjustment shim (2mm) optimal calibration is still not achieved, the spring (see "Nozzle-injector replacement") must be replaced.



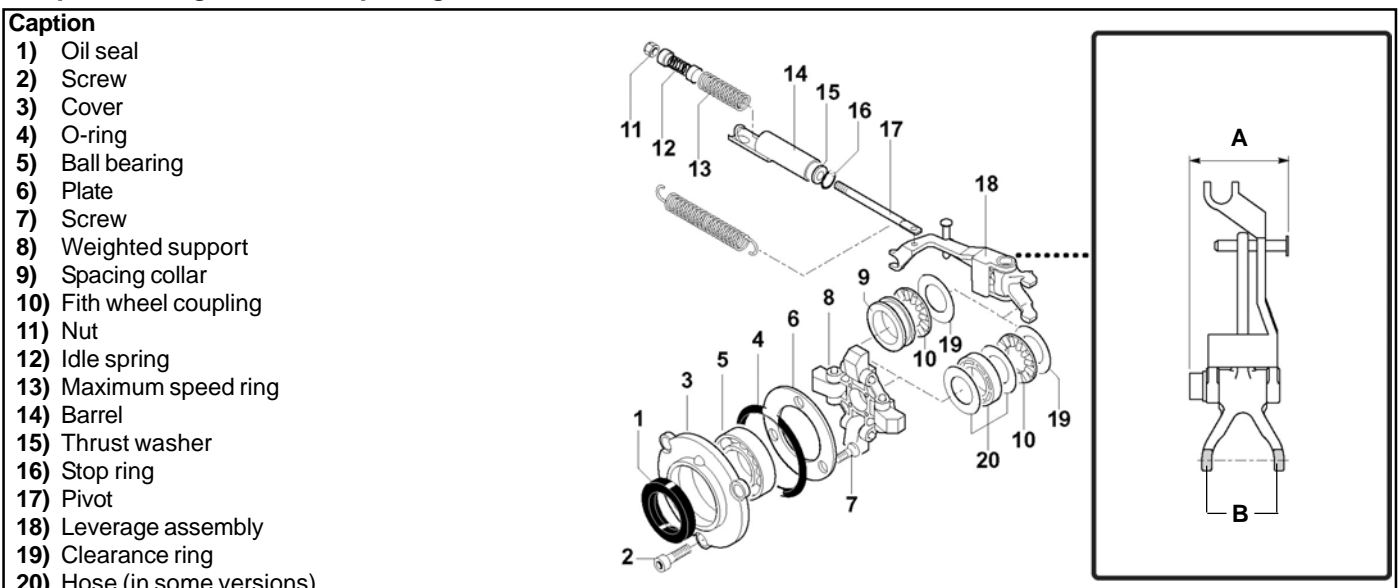
- 7 - After replacing the spring, calibrate at 10 bars higher than the optimal operating calibration of 140-155 bars. When the spring settles, the calibration will level at the optimal value.
- 8 - Remove the tool "7107-1460-074".
- 9 - Replace the non-return valve.
- 10 - Assemble the injection-pump on the engine (see "Assemble injection -pumps").

6.3.9 Checking and overhauling the speed governor

Disassemble the speed governor before checking or overhauling.
See "Disassembling the speed governor and flow limiter" for the correct procedure.

- 1 - Use a gauge to make sure that the distance **(A)** is between 45 and 46 mm.
- 2 - Make sure that the contact surfaces **(B)** are perfectly level with a deviation of no more than 0.05 mm. If the deviation is greater than this, replace the speed governor with an original spare.

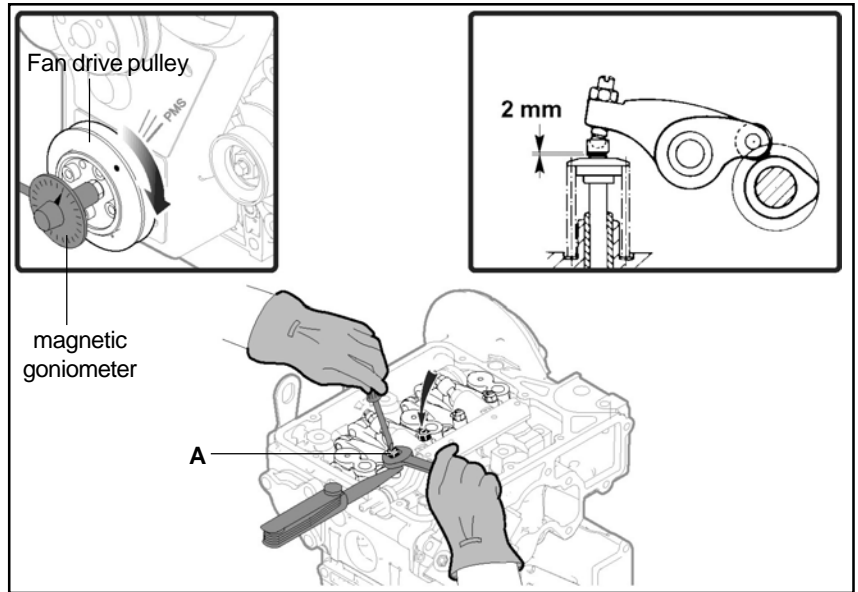
Exploded diagram of the speed governor



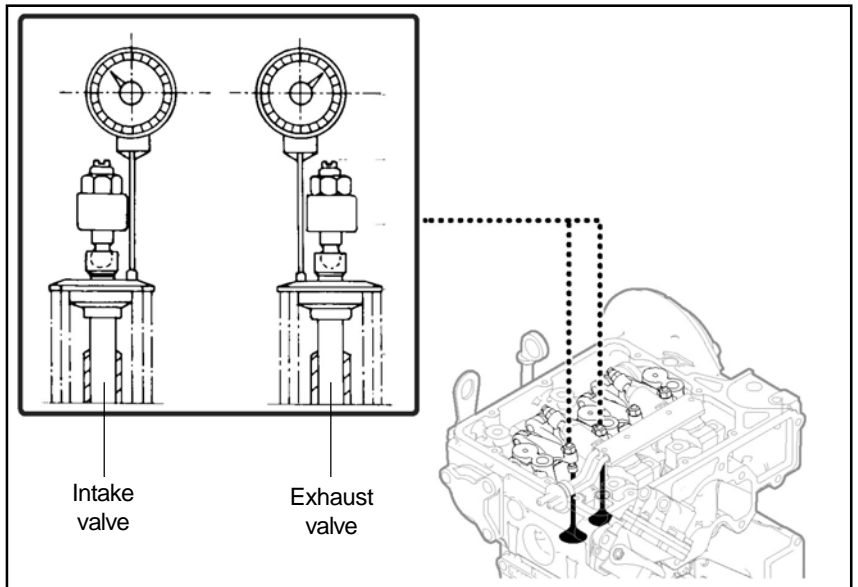
6.4 CHECKING TIMING BELT RATING

6.4.1 Valve adjustments

- 1 - Bring the piston to the compression top dead centre.
- 2 - Adjust the screw (A) and the lock nut in order to adjust the rocker arm valve clearance to 2 mm.
- 3 - Rotate the crankshaft clockwise through 360° in order to make the piston reaching the balancing top dead centre.
- 4 - Apply a magnetic goniometer on the crankshaft pulley and set it to zero.



- 5 - Place two dial indicators on the collars of the intake and exhaust valves, then set them to zero.
- 6 - Rotate the crankshaft clockwise until the dial indicator moves away from zero.
- 7 - Measure the rotation angle of the crankshaft by using the magnetic goniometer. The value registered indicates when the intake valve starts opening.
- 8 - Go on rotating the crankshaft clockwise until the dial indicator stops at point "0".
- 9 - Measure the rotation angle of the crankshaft by using the magnetic goniometer. The value registered indicates when the intake valve starts closing. The values registered must coincide with those indicated on the timing angle diagrams (see "Distribution timing angle diagram").
- 10 - Repeat these procedures on the other valves.



6.5 DIAGRAM OF TIMING BELT RATES

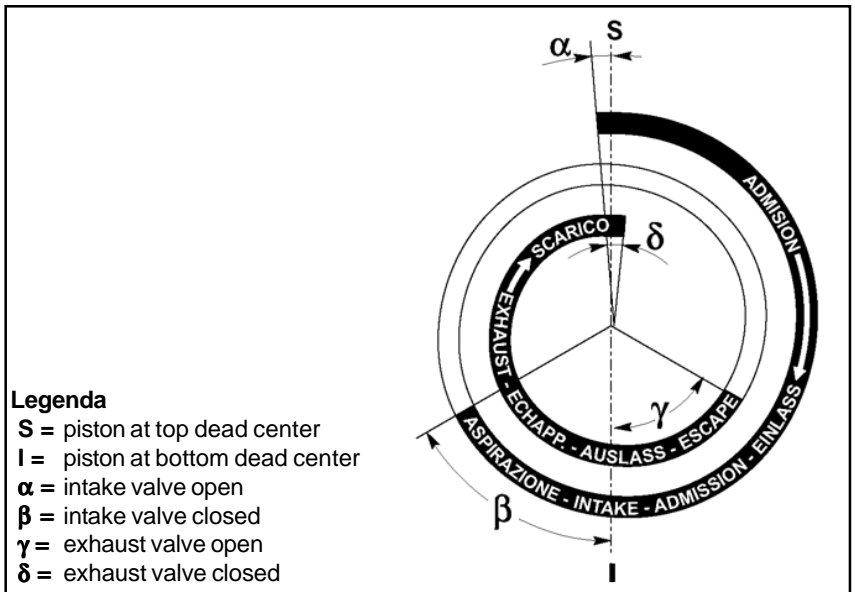
Rotate the crankshaft clockwise to find out the timing rates of the entire cycle in each cylinder (operation and control).

**Timing belt operating angles
(valve clearance 0.25 mm)**

- $\alpha = 14^\circ$ before **S** (top dead center)
- $\beta = 38^\circ$ after **I** (bottom dead center)
- $\gamma = 34^\circ$ before **I** (bottom dead center)
- $\delta = 18^\circ$ after **S** (top dead center)

**Timing belt control angles
(valve clearance 2 mm)**

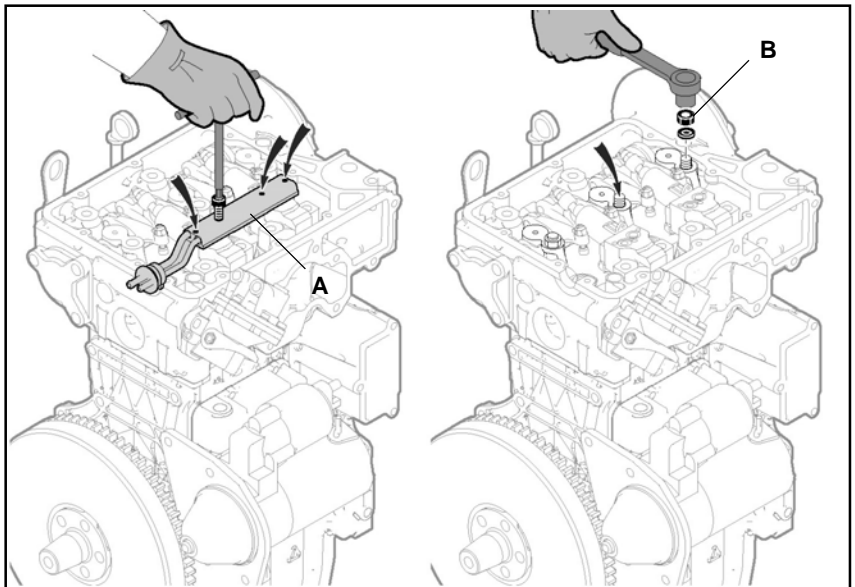
- $\alpha = 25^\circ$ after **S** (top dead center)
- $\beta =$ closes 2° after **I** (bottom dead center)
- $\gamma = 5^\circ$ after **I** (bottom dead center)
- $\delta = 18^\circ$ before **S** (top dead center)



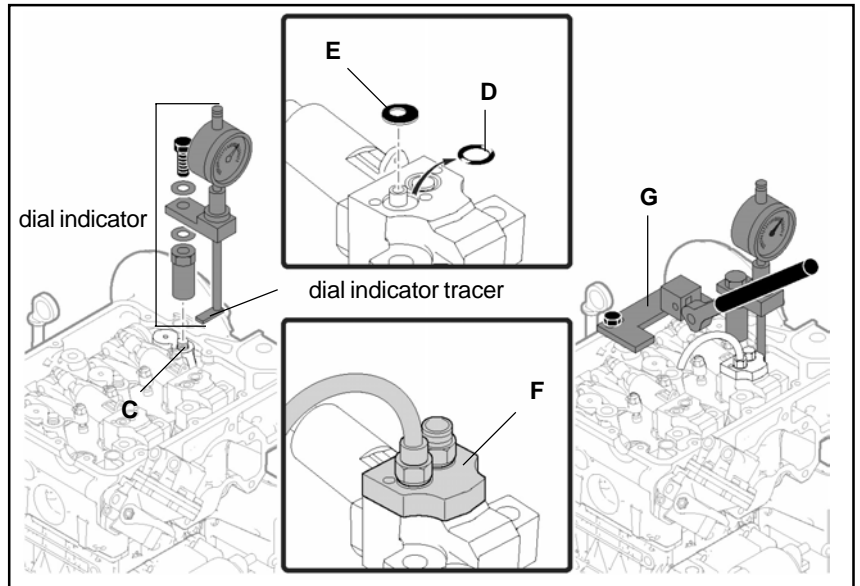
6.6 ADJUSTING STATIC INJECTION TIMING

In order to adjust injection timing, it is necessary to remove the rocker arm cover. See "Disassembling rocker arm cover" for the correct procedure.

- 1 - Disassemble the injector pump fuel rail (**A**).
- 2 - Select the cylinder on which the injection static advance adjustment will be carried out.
- 3 - Unscrew the rocker arm support nut (**B**) corresponding to the cylinder on which the procedure will be carried out.

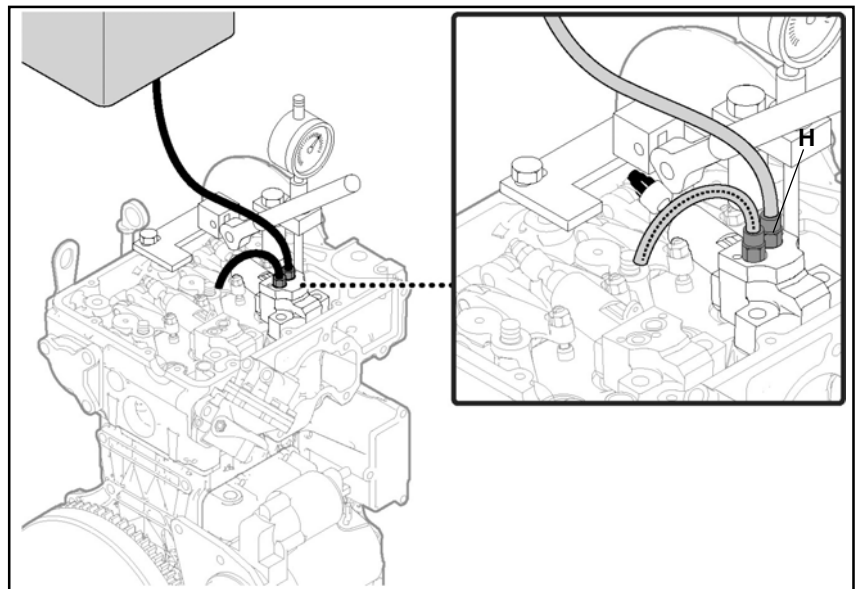


- 4 - Assemble the dial indicator on stud bolt (C).
- 5 - Place the dial indicator tracer on the exhaust valve collar.
- 6 - Remove the O-ring (D) from the little non-return valve and replace it with the suitable rubber cap (E) (part of tool "7107-1460-048").
- 7 - Install the tool metal base plate (F).
- 8 - Remove the rocker arm cover gasket.
- 9 - Fix the tool lever base (G) on cylinder head.
- 10 - Rotate the crankshaft clockwise until the injection cam acts on the rocker arm that controls the injector pump.

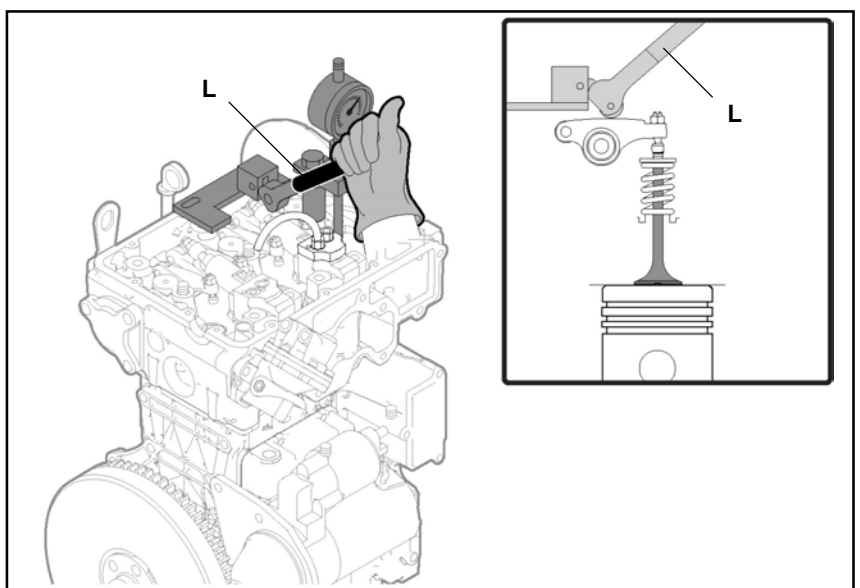


In these conditions, the piston is near the compression top dead centre.

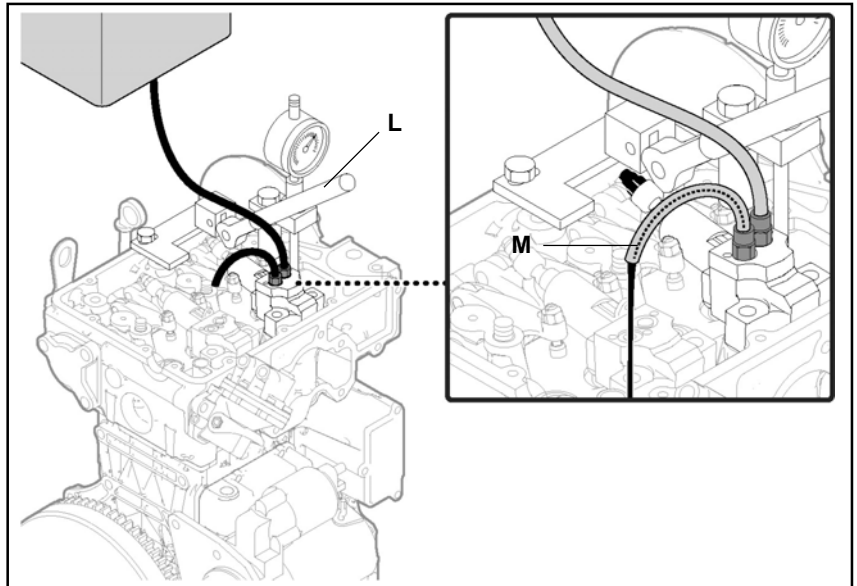
- 11 - Place the auxiliary tank at a height higher than that of the injectors (~30-40) cm.
- 12 - Connect the tank to union (H).



- 13 - Rotate slowly the crankshaft clockwise keeping the lever (L) lowered and the valve set on the piston crown, until the dial indicator shows the maximum measurement.
- 14 - Set the dial indicator to zero. In these conditions, the compression top dead centre can be identified.



- 16 - Rotate the crankshaft anticlockwise until liquid leaks from the pipe **(M)**, and then stop turning when the flow is constant and without air bubbles.
- 17 - Then turn slowly the crankshaft clockwise in order to identify the exact point at which liquid stops leaking. In these conditions, the point which coincides with the static injection timing can be identified.
- 18 - Act again on lever **(L)** to lower the valve and bring it again on the piston.
- 19 - Measure the piston lowering value by using the dial indicator.
- 20 - Convert the value registered from millimetres to degrees (see "Conversion table for establishing injection timing").



Conversion table for establishing injection timing

m m	injection advance angle	m m	injection advance angle
1,947	18°	0,733	11°
1,739	17°	0,606	10°
1,543	16°	0,491	9°
1,358	15°	0,388	8°
1,184	14°	0,297	7°
1,022	13°	0,218	6°
0,871	12°		



Important

- When converting, refer to the table value that is nearest to the registered one (see "Conversion table for establishing injection timing").
- For a good engine operation, the injection static advance must be as follows:
 - Engine with maximum speed up to 3000 rpm: 13° (± 1°)
 - Engine with maximum speed above 3000 rpm: 15° (± 1°)

If the static advance does not correspond to the ideal values, change the adjustment by means of the screw **(N)**.

To increase the angular value (higher static advance), turn the screw clockwise.

To decrease the angular value (lower static advance), turn the screw anticlockwise.



Important

Half turn of the screw equals approximately 5° of static angular advance.

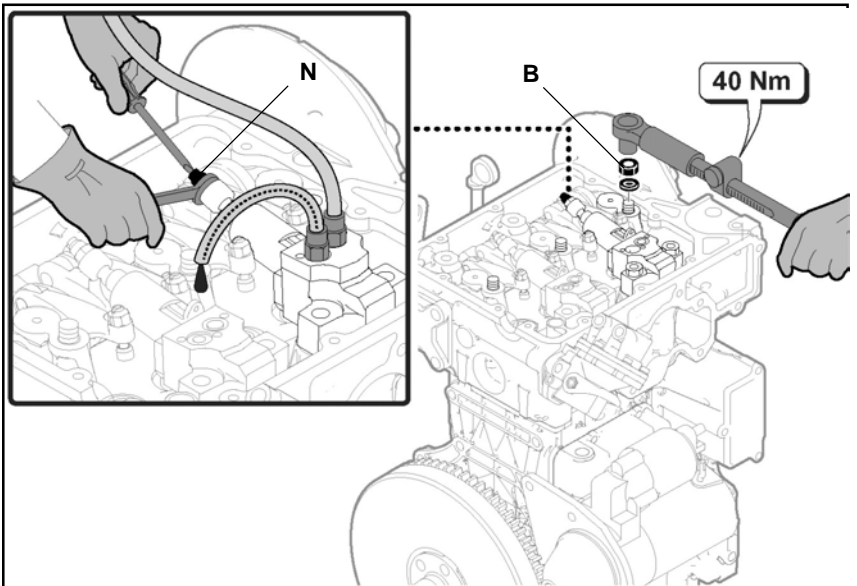
- 21 - Disassemble all equipment when the injection static advance is reached.

- 22 - Fasten and tighten the nut **(B)** to a final torque of 40 Nm.



Important

Repeat on the other cylinder.



23 - Once adjustment is finished, assemble the new O-rings (**D**) on the injector pumps.

Important

The O-rings must always be replaced with original spare parts whenever the fuel rail is disassembled.

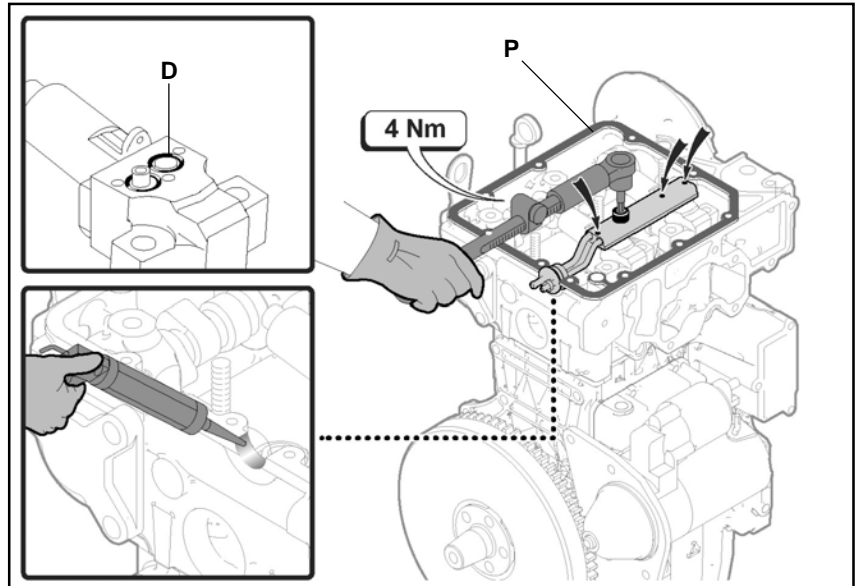
24 - Apply some silicone sealant on the fuel rail seat.

25 - Assemble the fuel rail and fasten the screws without tightening them.

26 - Tighten the screws to a final torque of 4 Nm.

27 - Slip on a new gasket (**P**).

28 - Reassemble the rocker arm cover (see "Assembling the rocker arm cover").



6.7 BALANCING THE INJECTION-PUMP DELIVERY

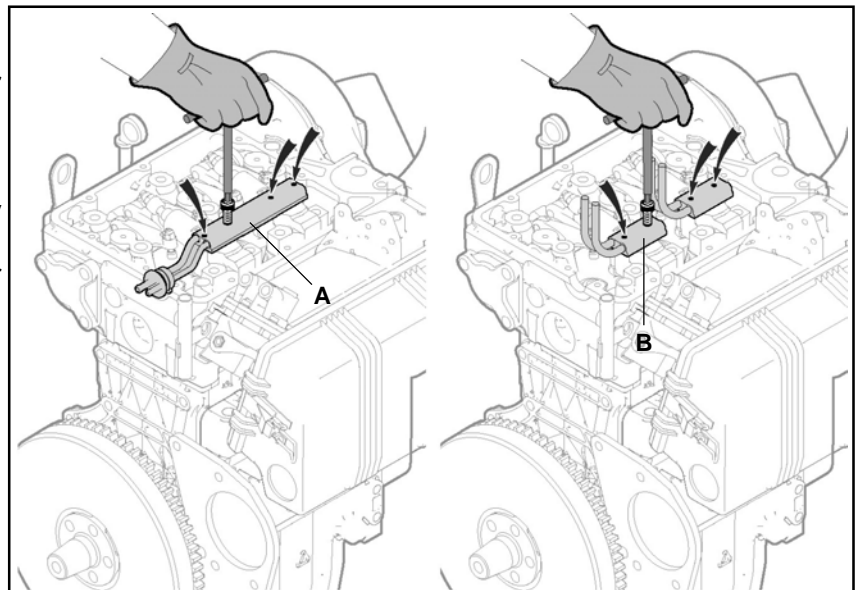
Importante

It is necessary to balance delivery whenever the injection-pump is replaced.

In order to work on the injector, it is necessary to remove the rocker arm cover. See "Disassembling the rocker arm cover" for the correct procedure.

1 - Remove the fuel rail (**A**).

2 - Mount the "7107-1460-127" tool heads (**B**).

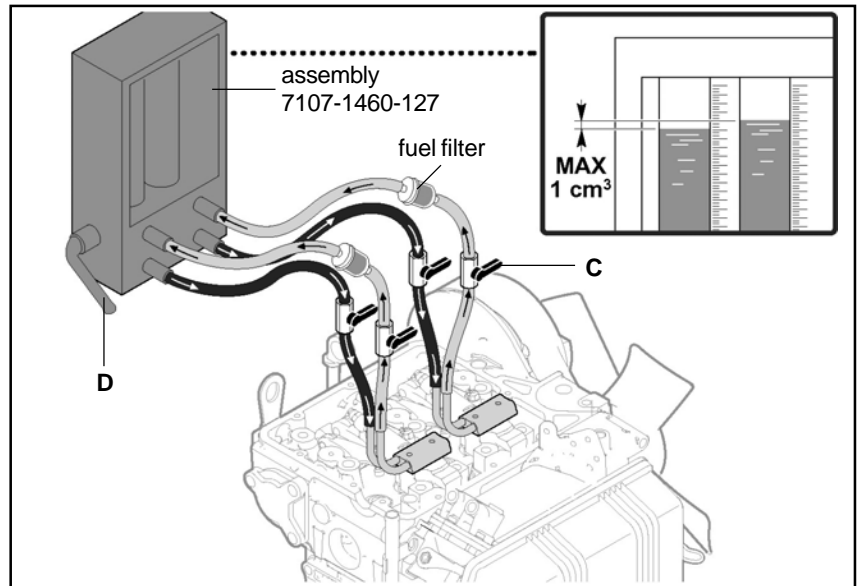


- 3 - Position the assembly "7107-1460-127" above the height of the injectors.
- 4 - Connect the outlet and intake pipes of the assembly to the test heads.

Important

Be careful not to reverse the intake and outlet pipes when connecting.

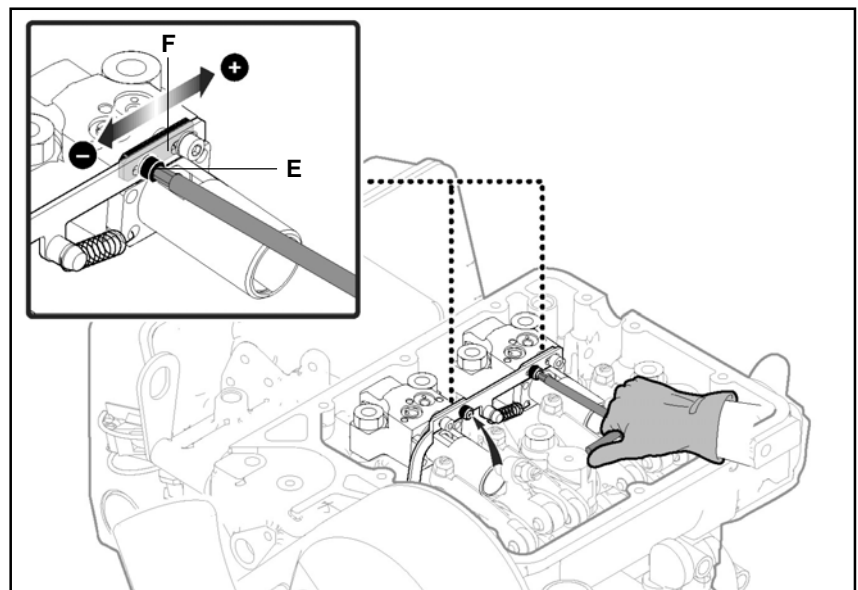
- 5 - Open the cocks (C).
- 6 - Start the engine and keep it at minimum idle speed (~ 1150÷1250 Rpm).
- 7 - Turn the equipment switching valve by means of the lever (D).
(The engine is supplied by tubes and no more by tool tank).
- 8 - Check the level of the test heads after 1 minute.
- 9 - Make sure the difference in volume is no greater than 1 cm³.



Important

If the difference is greater, increase delivery of the injector pump with the highest level, or reduce the one with the lowest level.

- 10 - Loosen the screw (E) to adjust delivery at the injector.
- 11 - Shift the plate (F) gently in one of the two directions. Shift the plate towards the flywheel to increase delivery. Shift the plate towards the timing belt to reduce delivery.
- 12 - Tighten the screw (E) to a torque of 1.1Nm.
- 13 - Close the cocks and disconnect the assembly.
- 14 - Put the new O-rings on the injector pumps.
- 15 - Apply sealant to the seat of the fuel rail.



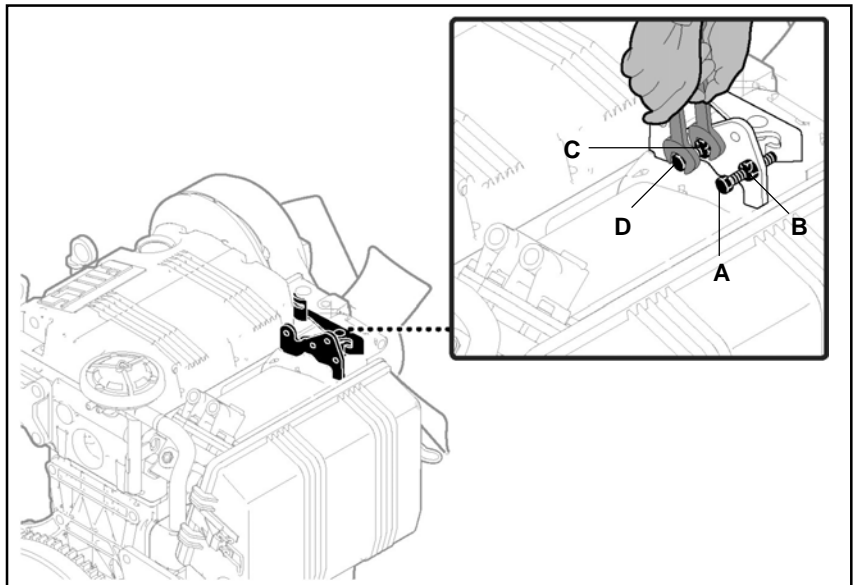
Important

The O-rings must always be replaced with original spares whenever the fuel rail is disassembled.

- 16 - Assemble the fuel rail and fasten the screws without tightening them completely.
- 17 - Tighten the screws to a torque of 4Nm.

6.8 ADJUSTING MINIMUM AND MAXIMUM IDLE SPEED RPMS

- 1 - Connect a revolution counter to the engine.
- 2 - Run the engine and bring it to the operating temperature.
- 3 - Turn the idle adjusting screw **(A)** and set the engine to the minimum speed required.
- 4 - Tighten the lock nut **(B)** when finished.



Important

To decrease the rpm number, loosen the screw. To increase it, tighten the screw.

- 5 - Turn the peak-rpm adjusting screw **(D)** and set the engine to the maximum speed required.
- 6 - Tighten the lock nut **(C)** when finished.

Important

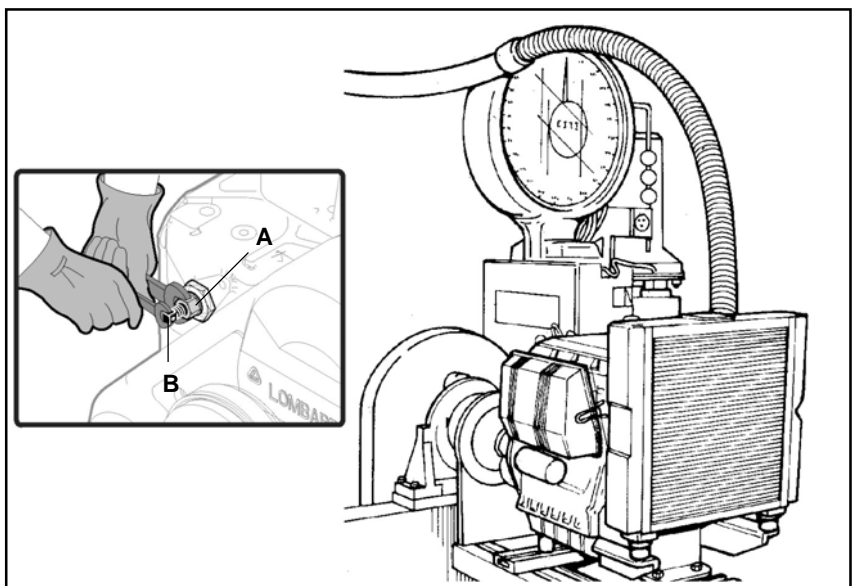
To decrease the rpm number, tighten the screw whereas to increase it loosen the screw.

6.9 ADJUSTING INJECTION DELIVERY

The adjustment may be performed with the dynamometric brake (accurate adjustment) or without it (approximate adjustment).

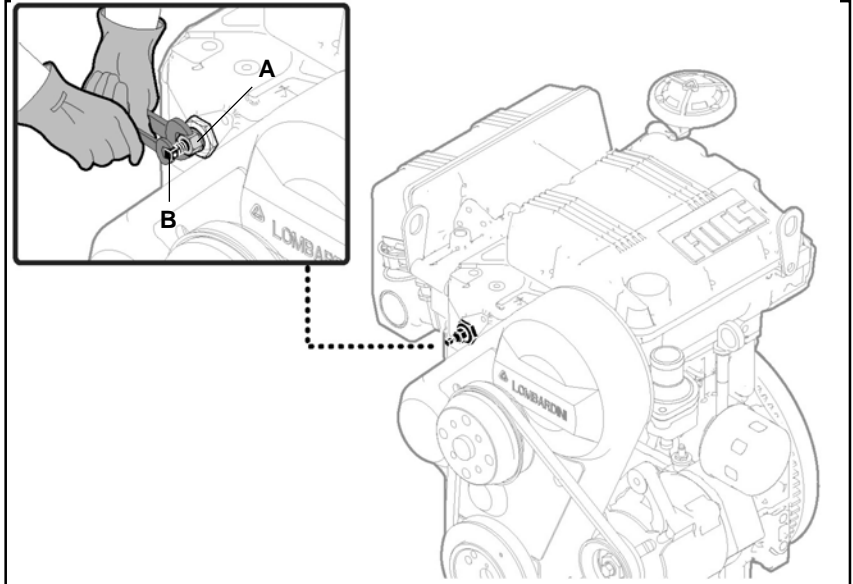
6.9.1 Adjusting injection delivery (without dyno break)

- 1 - Loosen locknut **(A)**.
- 2 - Firmly tighten the screw **(B)** of the flow limiter.
- 3 - Start the engine and bring it to the operating temperature.
- 4 - Bring the engine to maximum rpm allowed.
- 5 - Loosen the screw **(B)** of the flow limiter until the engine speed starts to decrease.
- 6 - Retighten the screw rotating it 2.5 revolutions, then fasten with the lock nut **(A)**.



6.9.2 Adjusting injection delivery (with dyno break)

- 1 - Start the engine and bring it to the operating temperature.
- 2 - Bring the engine to maximum rpm allowed.
- 3 - Loosen the locknut **(A)**.
- 4 - Firmly tighten the screw **(B)** of the flow limiter.
- 5 - Activate the dyno brake to bring the engine to maximum power and speed.
- 6 - Make sure that fuel consumption corresponds to the recommended values (see "Table of specific fuel consumption").
If fuel consumption does not correspond to the values shown, reduce the load of the dyno brake.
- 7 - After a few minutes of running the engine and when it has "stabilised", slowly unscrew the limiter screw **(B)** until the speed starts to decrease.
- 8 - Fasten the screw **(B)** with the locknut **(A)**.
- 9 - Deactivate the dyno brake and take note of the "stabilized" engine speed.
- 10 - Switch off the engine and leave to cool.
- 11 - Check the valve-rocker arm clearance (see "Adjusting valve/rocker arm clearance").



Important

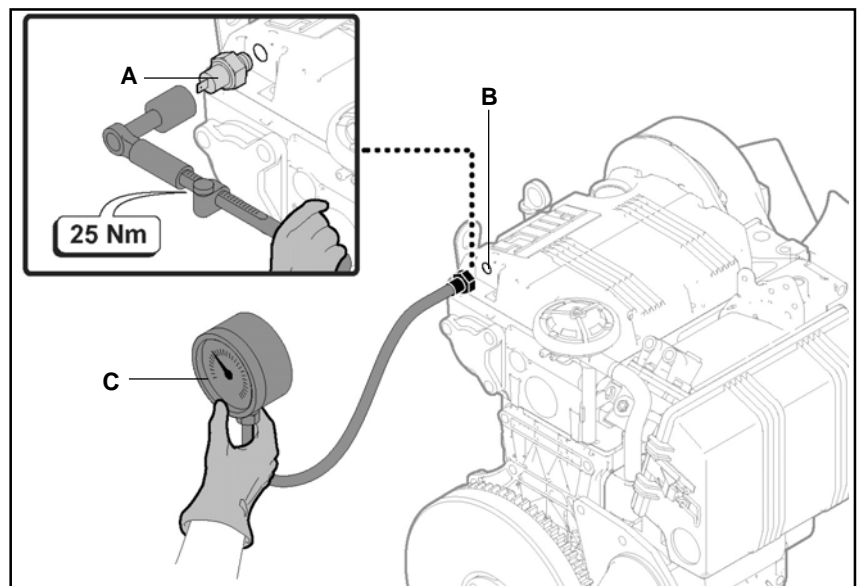
If the engine gives off too many fumes at maximum load, loosen the flow limiter screw. If it gives off no fumes or does not achieve maximum power, tighten the flow limiter screw.

Table of specific fuel consumption

Motor speed	Power curve NB ^(a)	Specific fuel consumption	
		Time-secs. per 100 cc	g/Kwh
Rpm	Kw		
2200	5,51	192÷183	285÷299
3000	7,38	125÷129	315÷325
3600	7,72	120÷115	326÷340

6.10 CHECKING OIL PREASSURE

- 1 - Remove the preassure switch **(A)**.
- 2 - Mount a union in the hole **(B)** and connect to a 10-bar pressure gauge **(C)**.
- 3 - Start the engine and bring it to the operating temperature.
- 4 - Start the engine and bring it to a speed of 900 RPM, while at the same time making sure that the pressure gauge shows a pressure of 1 bar (oil temperature 80÷120 °C).
- 5 - Switch off the engine.
- 6 - Remove the pressure gauge **(C)** and the union **(B)**.
- 7 - Replace the pressure switch **(A)** and tighten it to a torque of 25Nm.



A series of horizontal dotted lines providing a template for writing.

7.1 RECOMMENDATIONS FOR INSTALLING THE ASSEMBLIES

- Information is given in a logical order in terms of timing and sequence of operations. The methods have been selected, tested and approved by the manufacturer's technical experts.
- This chapter describes procedures for installing assemblies and/or individual components that have been checked, overhauled or replaced with original spare parts.

Important

To locate specific topics, the reader should refer to the index.

- The operator must wash, clean and dry components and assemblies before installing them.
- The operator must make sure that the contact surfaces are intact, lubricate the coupling parts and protect those that are prone to oxidation.
- Before any intervention, the operator should lay out all equipment and tools in such a way as to enable him to carry out operations correctly and safely.

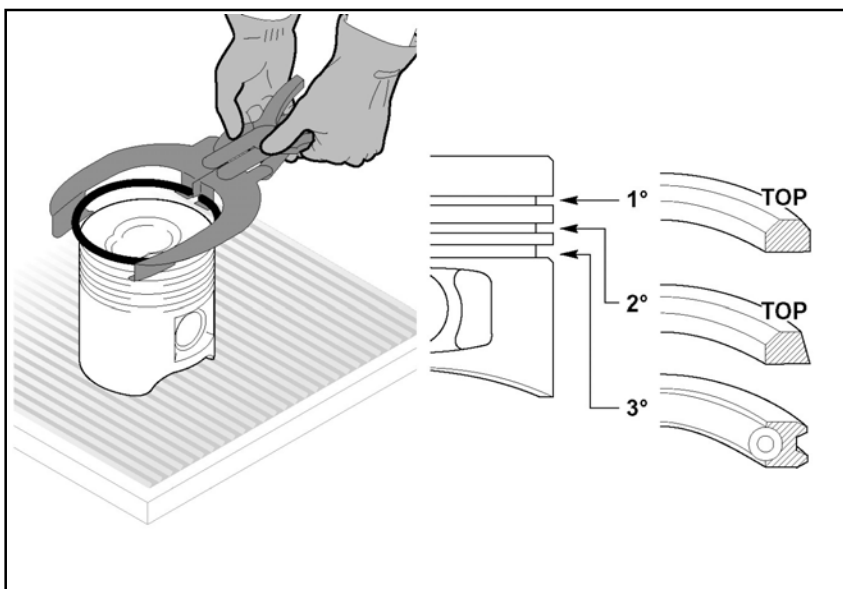
- For safety and convenience, you are advised to place the engine on a special rotating stand for engine overhauls.
- Before proceeding with operations, make sure that appropriate safety conditions are in place, in order to safeguard the operator and any persons involved.
- In order to fix assemblies and/or components securely, the operator must tighten the fastening parts in a criss-cross or alternating pattern.
- Assemblies and/or components with a specific tightening torque must initially be fastened at a level lower than the assigned value, and then subsequently tightened to the final torque.

7.2 PRE-ASSEMBLY OF SEALING RINGS-PISTONS

- Thoroughly clean the pistons and lubricate the coupling areas.
- Put the sealing rings on the piston in the order shown in the figure.

Important

- Place the sealing rings with the markings facing up towards the upper part of the piston (crown).
- Keep the pistons together with their own connecting rods and wrist pins.



7.3 PRE-ASSEMBLY OF CONNECTING RODS - PISTONS

Important

Before pre-assembly, check that the weight difference between the two connecting rod-piston-wrist pin assemblies does not exceed 10 g to prevent weight imbalances.

- 1 - Lubricate the wrist pin (A) and the seat of the small end of the connecting rod (B).
- 2 - Place the lock ring (C) on the piston complete with sealing rings (D).

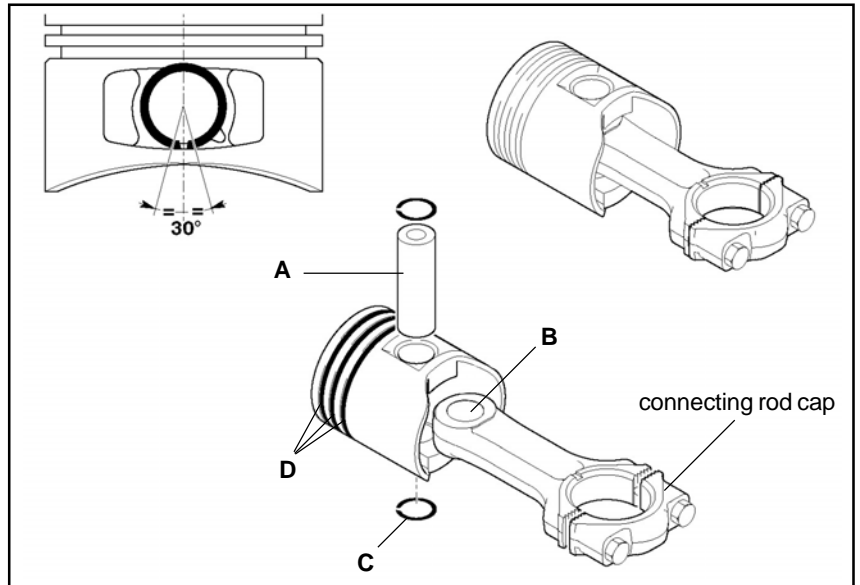
Important

Insert the lock rings with the tips pointing towards the base of the piston with a tolerance of 15°.

- 3 - Insert the wrist pin (A) into the piston (D) and install the connecting rod (B) (complete with cap).
- 4 - Insert the wrist pin completely and fasten with the lock ring.

Important

- Make sure the lock rings are positioned correctly in their seats.
- Lubricate the coupling parts and those that are prone to oxidation.



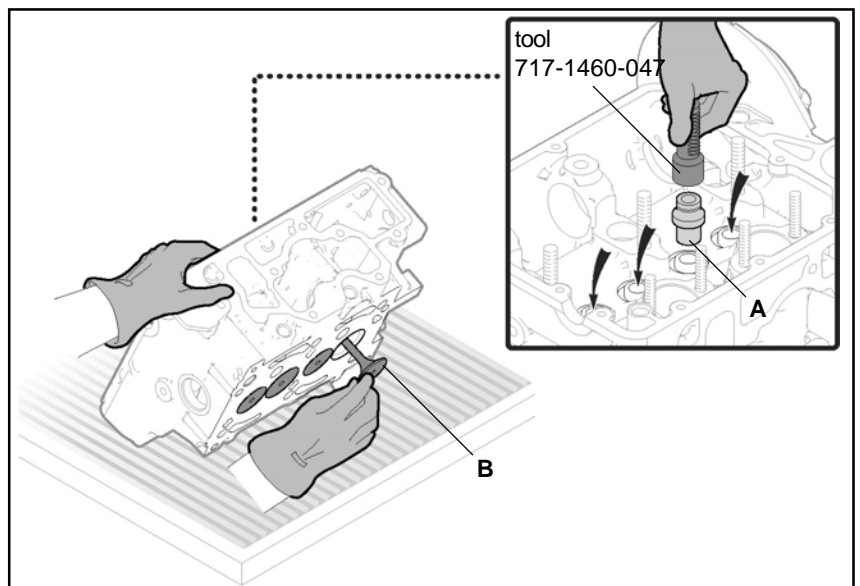
7.4 INSTALLING VALVES

7.4.1 Assembling the valves

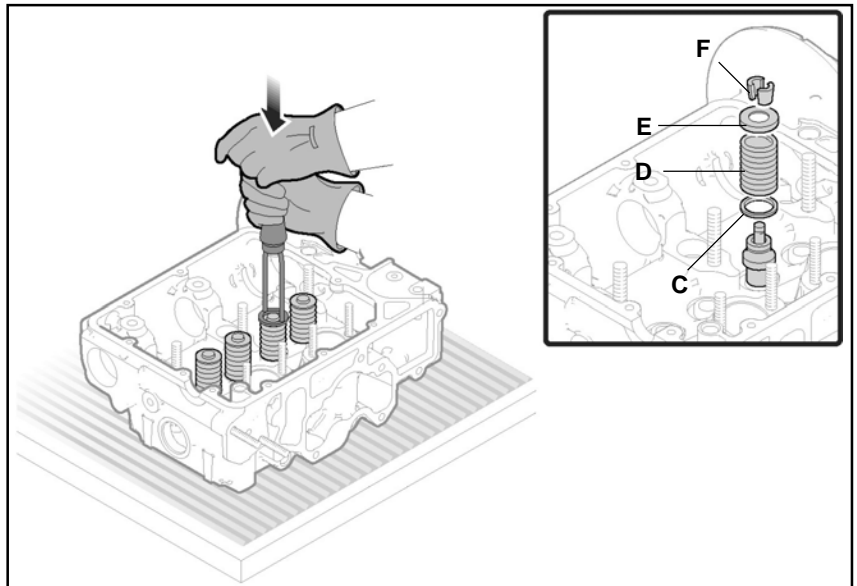
Important

- Make sure that the cylinder head is perfectly clean and dry.
- Check that all components are intact and, if necessary, replace them with original spares.

- 1 - Lubricate the valve stem sealing ring (A), insert it into tool "717-1460-047", and mount it right into the seat of the valve guide.
- 2 - Lubricate the valve stem (B).
- 3 - Slip the valve into the seats.



- 4 - Mount the collar (C), the spring (D), the cup (E) and the half collets (F).
- 5 - Press down hard on the cup (E), using the special tool "7107-1460-047" to insert the half collets (F) into the valve stem groove.
- 6 - Release the tool and check that the half collets are positioned correctly. If the half collets are not correctly positioned, repeat the operation.
- 7 - Repeat the same operation on the other valves.



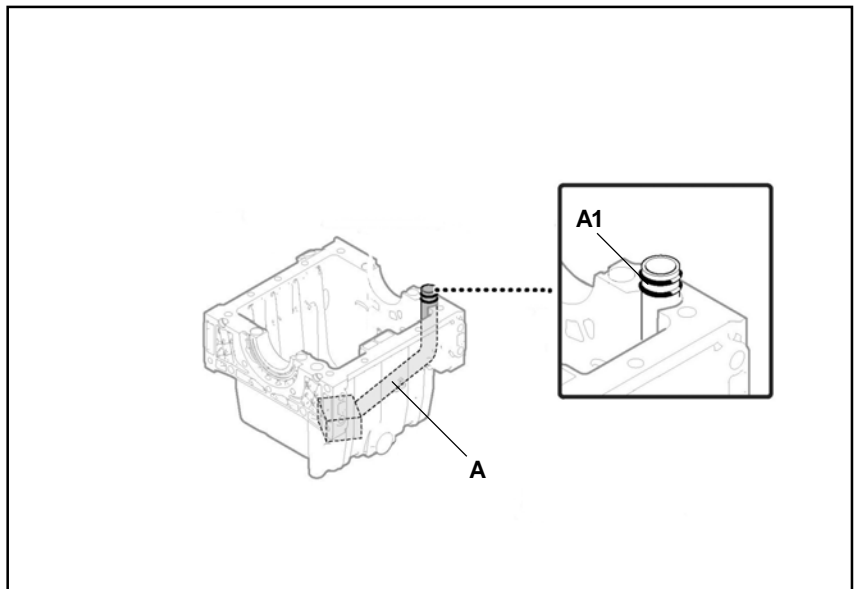
7.5 INSTALLATION OF CRANK GEAR AND CRANKCASE

7.5.1 Installing piston/connecting rod - engine block



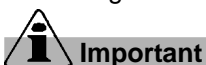
Make sure that the engine block and the crankcase are perfectly clean and dry.

- 1 - Assemble the pipe (A) with the oil suction filter.
- 2 - Mount the new O-rings (A1).
- 3 - Carefully clean and lubricate the cylinders and the connecting rod-piston assembly (B).
- 4 - Rotate the sealing rings so that the cuts have a displacement of about 120° between them.

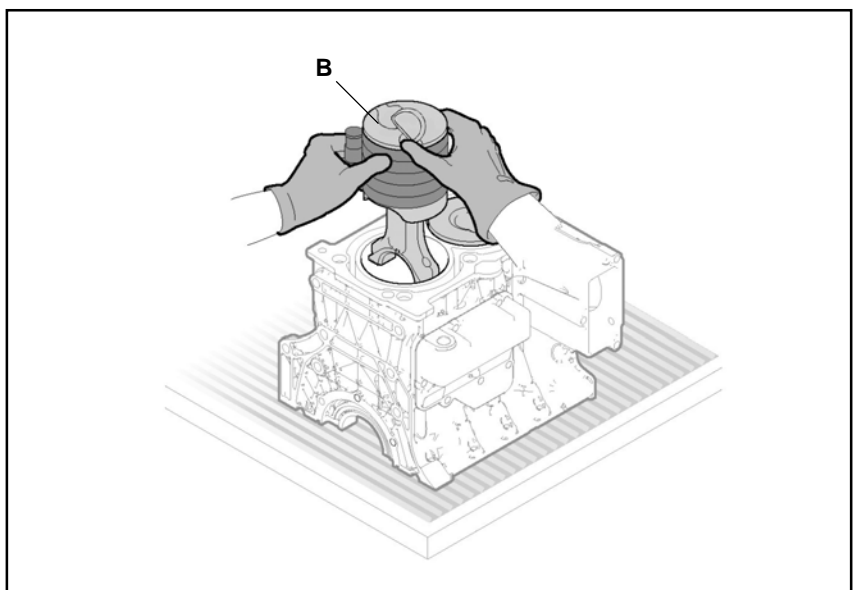


In order not to damage the sealing rings and the contact areas while inserting the piston into the cylinder, use the special containment device.

- 5 - Mount the connecting rod-piston assembly (B) onto the engine block and position the connecting rod big ends along the axis of the crankshaft.



The piston combustion chamber must be assembled on the precombustion chamber.



7.5.2 Assembling the crankshaft

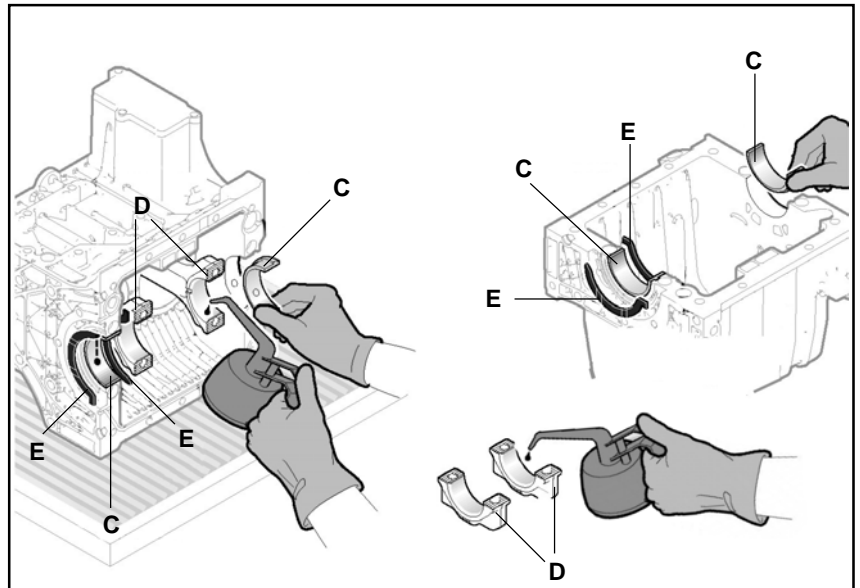
- 1 - Mount the half-bearings (C) and the standard shoulder half-rings (E) (flywheel side).



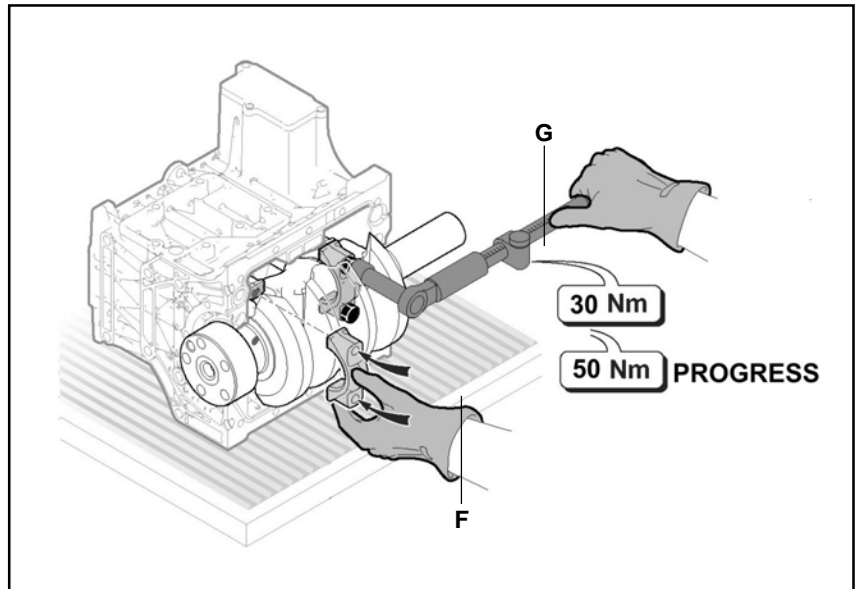
Important

- Follow the marks made during the removal phase.
- The shoulder half-rings must be placed with the lubrication grooves facing outwards.

- 2 - Lubricate the half-bearings (C), the connecting rod big ends (D) and caps (F).
- 3 - Carefully lubricate the crankshaft main journals and crank pins.



- 4 - Assemble the crankshaft (G).
- 5 - Replace the connecting rod caps (F) and put in the screws.
- 6 - Tighten the connecting rod cap screws to a temporary torque of 25Nm.
- 7 - Tighten the connecting rod cap screws to a final torque of 30 Nm (50 Nm x PROGRESS).
- 8 - Assemble the crankcase (see "Assembling the crankcase").
- 9 - Measure the axial clearance of the crankshaft (see "Measuring crankshaft axial clearance").



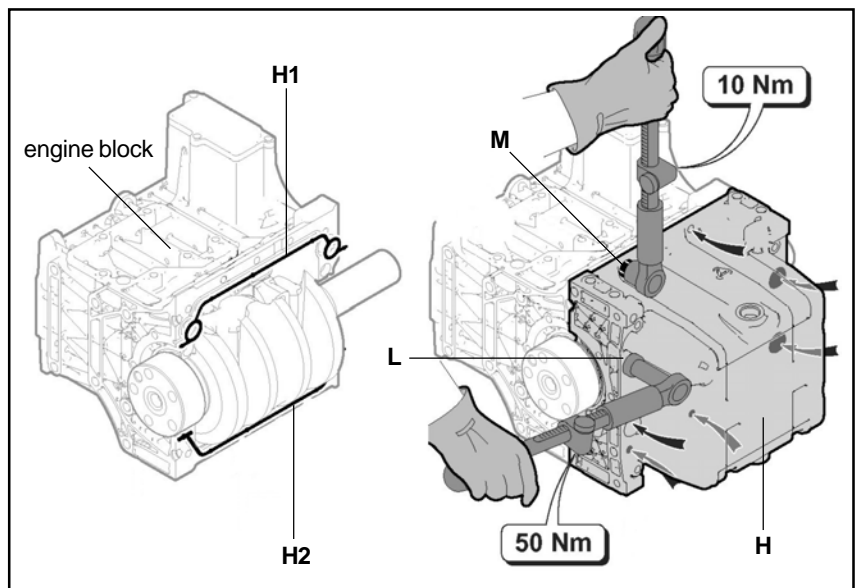
7.5.3 Assembling the crankcase



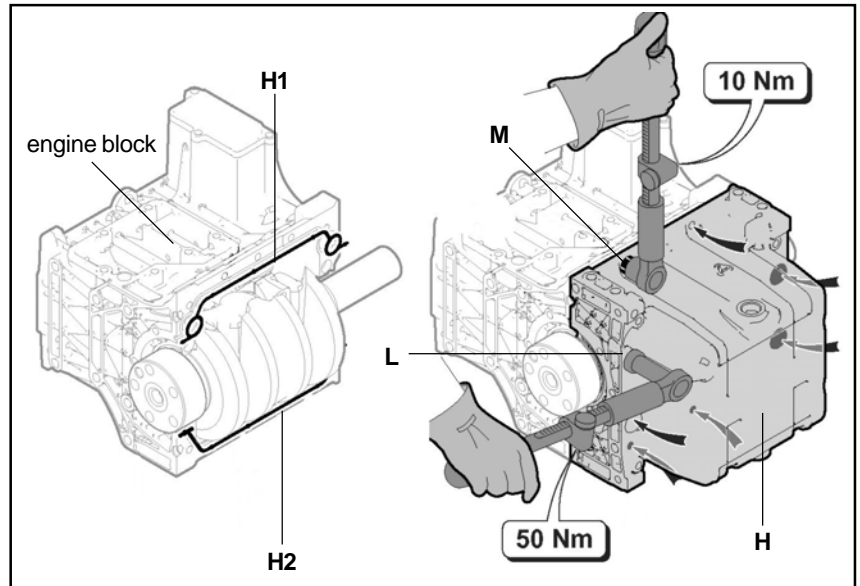
Important

- Make sure that the contact surfaces and related pins are perfectly intact and clean.
- Make sure there are no foreign bodies or residual material in the engine block and crankcase.

- 1 - Mount the new gaskets (H1- H2) for the engine block contact surface with the crankcase.
- 2 - Replace the crankcase (H) and put in the screws (L-M).
- 3 - Tighten the screws (L) temporarily in a crisscross pattern.



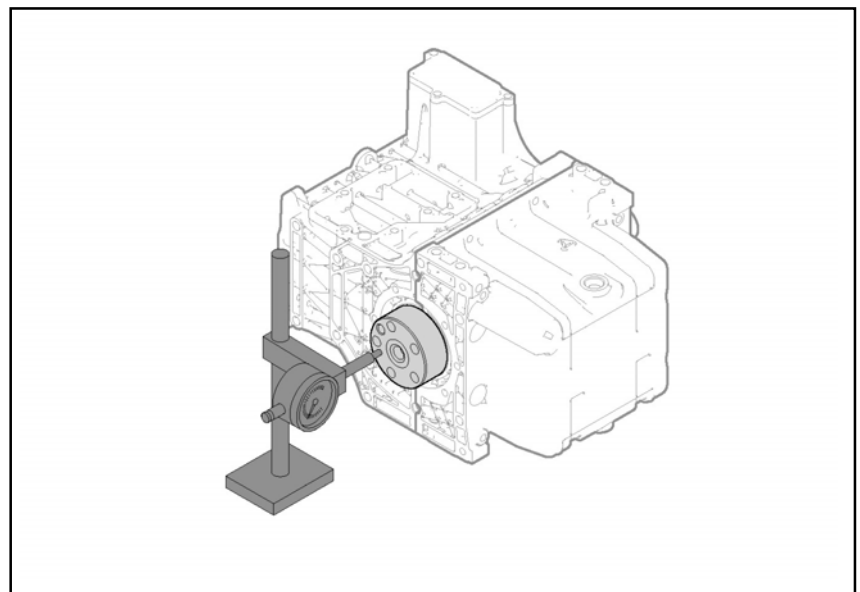
- 4 - Tighten the screws **(M)** temporarily in alternating pattern.
- 5 - Tighten the screws **(L)** in a crisscross pattern to a final torque of 50Nm.
- 6 - Tighten the screws **(M)** in an alternating pattern to a final torque of 10Nm.



7.5.4 Measuring crankshaft axial clearance

To measure the axial clearance of the crankshaft, it is necessary to assemble the shaft complete with crankcase.
See "Assembling the crankcase" for the correct procedure.

- 1 - Using a dial indicator, measure the axial shift of the crankshaft.
Axial shift must be between 0.130 and 0.313mm. If axial shift is above these values, it is necessary to insert uprated shoulder half-rings and once again disassemble the crankcase (see "Dimensional check and overhaul of crankshaft").



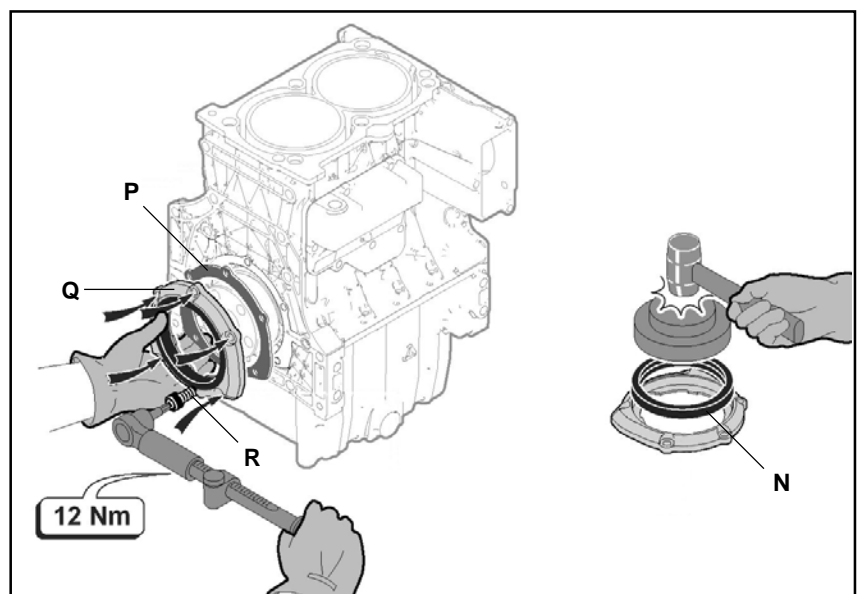
7.5.5 Assembling the crankshaft flange (flywheel side)

- 1 - Clean the flange and the sealing ring seat **(N)**.
- 2 - Using the special pad, insert a new sealing ring **(N)** into the flange **(Q)**.

Important

Given the particular function played by this sealing ring, it is important to use only original spares.

- 3 - Check that the contact surfaces are perfectly clean and intact.

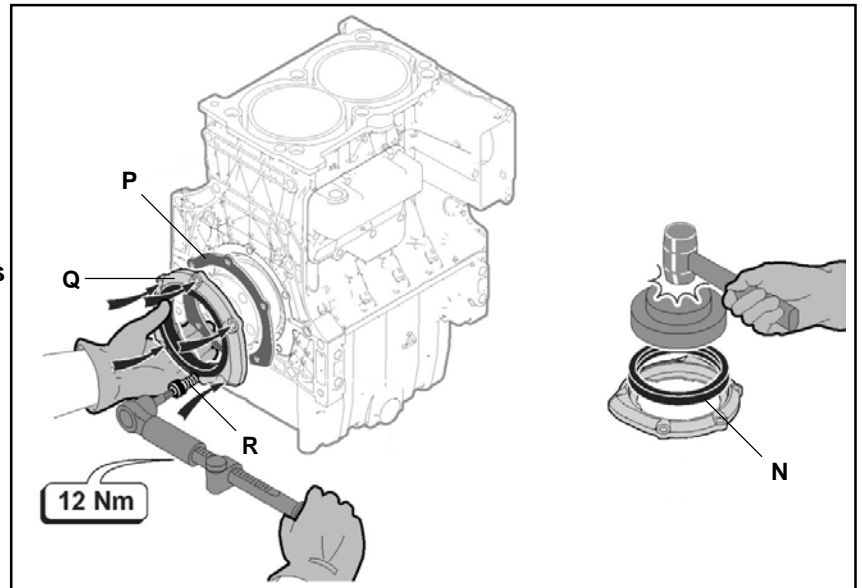


- 4 - Slip on a new gasket (P).
- 5 - Replace the flange (Q) and put in the screws (R).

Important

Be careful not to damage the sealing rings during this operation.

- 6 - Tighten the screws (R), in a crisscross pattern to a final torque of 12Nm.



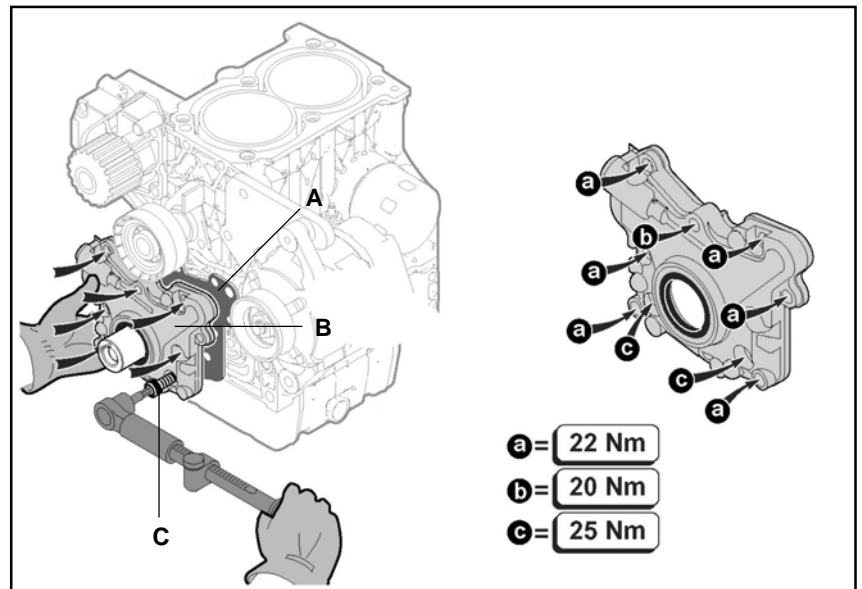
7.5.6 Installing the oil pump

Before installing the oil pump, make sure there are no malfunctions (see "Check and overhaul the oil pump").

Important

Check that the contact surfaces are perfectly clean and intact.

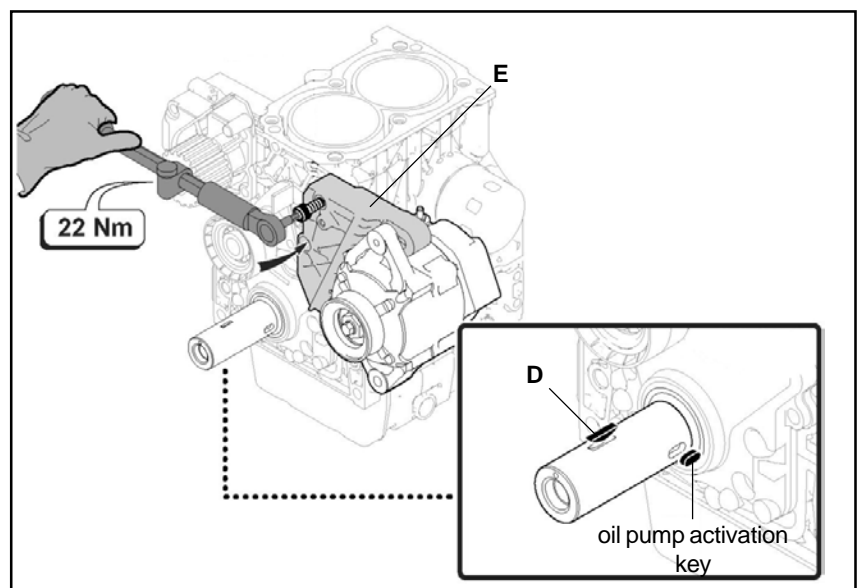
- 1 - Slip on a new gasket (A).



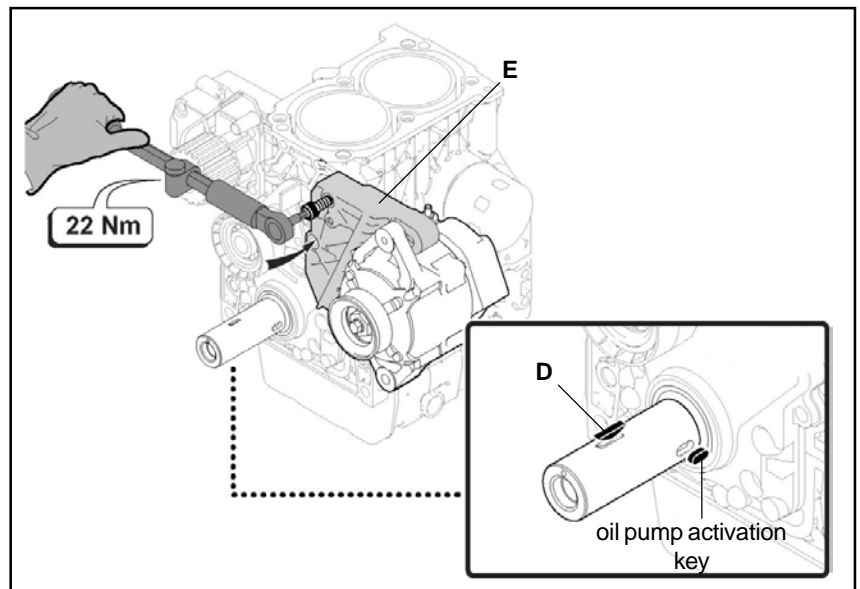
- 2 - Insert the oil pump activation key into the crankshaft.
- 3 - Bring piston number one (flywheel side) to the top dead centre, with the oil pump activation key in line with break in the flange, in order to be able to assemble the pump.
- 4 - Install the pump (B) and put in the screws (C).

Important

Be careful not to damage the sealing rings during this operation.

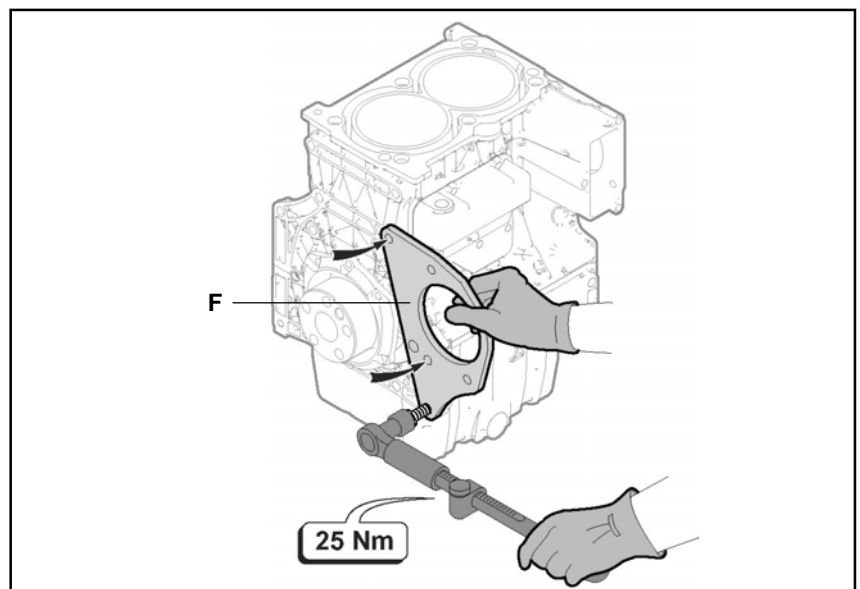


- 5 - Tighten the screws in a crisscross pattern, and tighten each of them to their respective final torques (see image).
- 6 - Insert the key (D) into the crankshaft.
- 7 - Install the alternator support (E) and tighten the screws to a torque of 2.2Nm.



7.5.7 Assembling the flywheel

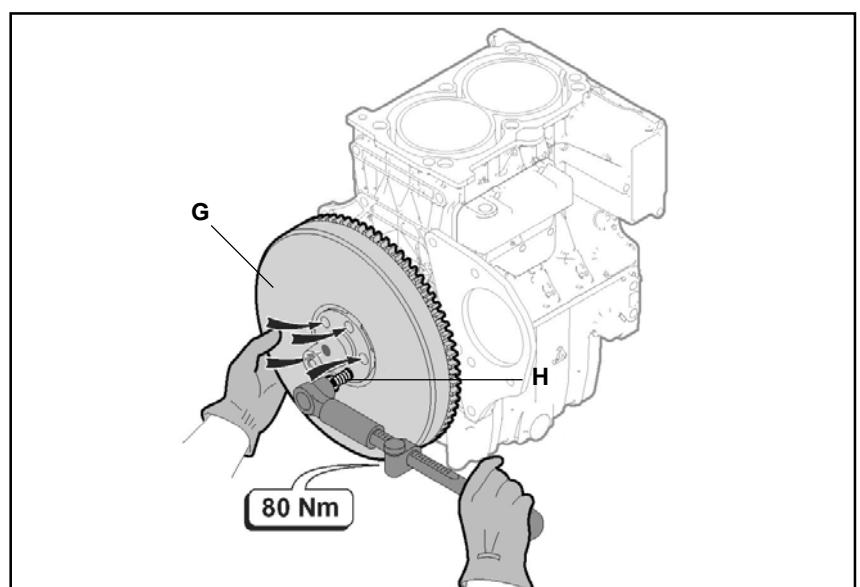
- 1 - Install the support (F) and tighten the screws to a torque of 25 Nm.



- 2 - Install the flywheel (G) and put in the screws (H).
- 3 - Tighten the screws temporarily in a crisscross pattern.
- 4 - Tighten the screws in a crisscross pattern to a final torque of 80Nm.

Important

Turn the flywheel manually to check the movement of the mechanical parts.



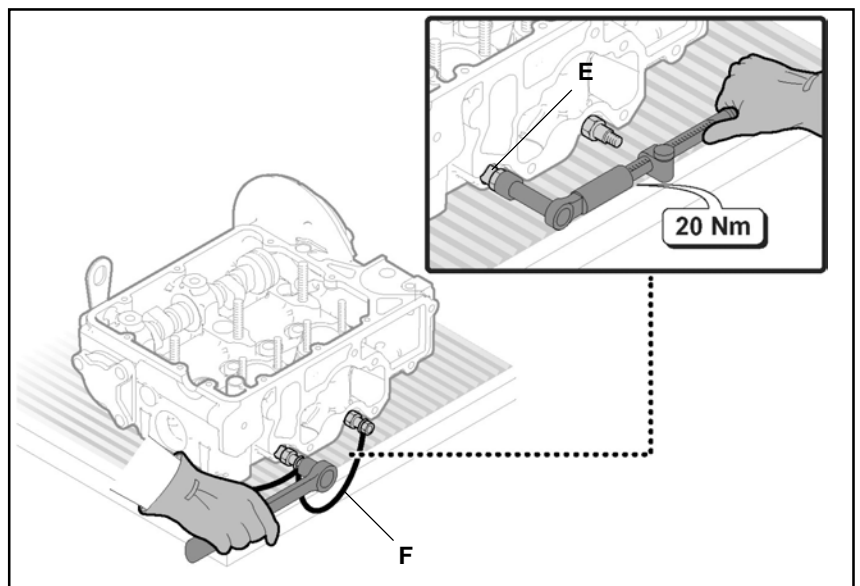
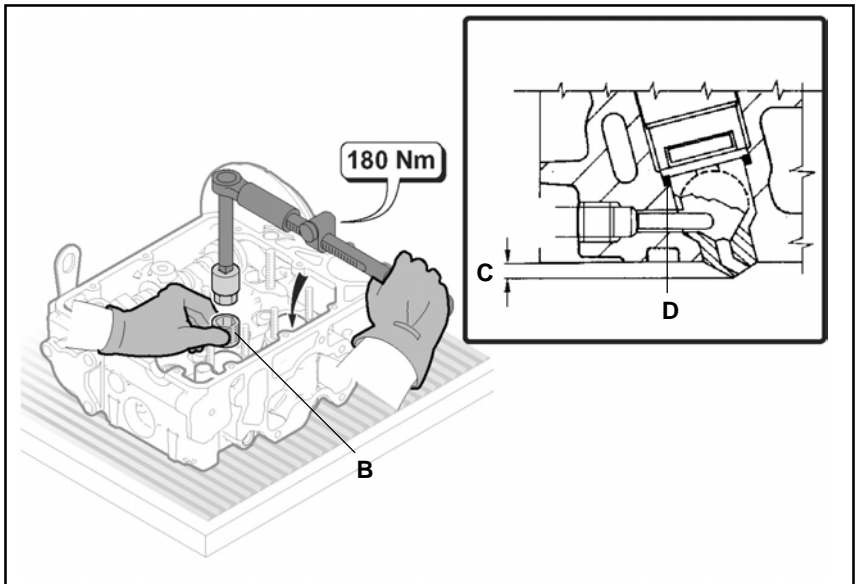
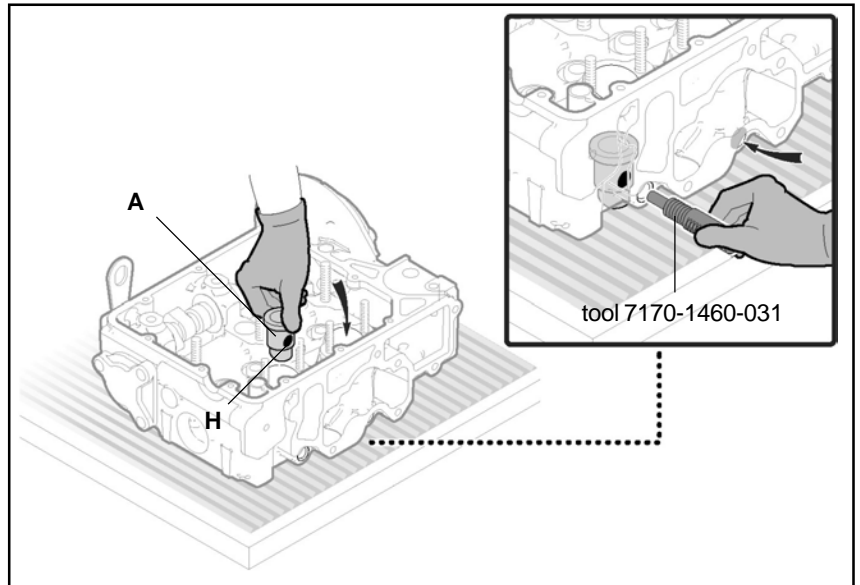
7.6 INSTALLATION OF CYLINDER HEAD AND COMPONENTS

7.6.1 Assembling the precombustion chamber



Check that the contact surfaces are perfectly clean and intact.

- 1 - Install the precombustion chamber (**A**), so that its hole (**H**) coincides with the one on the pre-heating glow plug.
- 2 - Insert tool "7107-1460-031" into the seat of the preheating glow plug in order to lock the chamber while the ring nut (**B**) is being tightened.
- 3 - Apply some anti-seize product to the ring nut thread (**B**) and to the surface that is in contact with the precombustion chamber.
- 4 - Mount the ring nut (**B**).
- 5 - Tighten the ring nut to a temporary torque of 100Nm.
- 6 - Make sure that the precombustion chamber protrusion (**C**) is between 3.56÷4.04 mm. If the protrusion (**C**) exceeds the recommended value, insert a shim (**D**) (provided ad spare part) beneath the precombustion chamber (**A**).
- 7 - Tighten the ring nut to a final torque of 180Nm.
- 8 - Remove the tool and install the preheating glow plug (**E**).
- 9 - Tighten the glow plug to a torque of 20 Nm.
- 10 - Repeat the same operations on the other chamber.
- 11 - Connect the glow plug power supply cable (**F**).

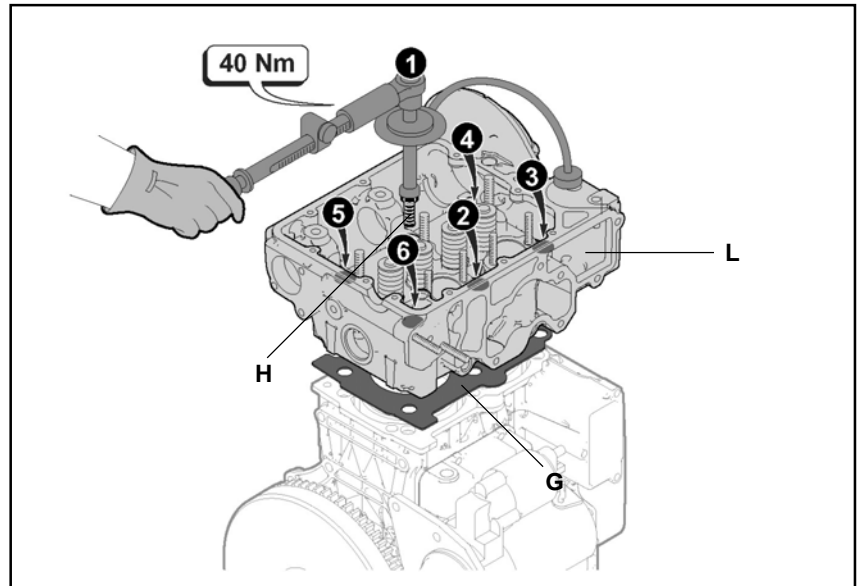


7.6.2 Assembling cylinder head

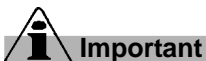


- Make sure there are no foreign bodies or residual material in the cylinder head cavity.
- Check that the contact surfaces are perfectly clean and intact.

- 1 - Slip on a new gasket (G).
- 2 - Choose the gasket shim to be installed (see "Check clearance volume")
- 3 - Make sure that the length of the screws (H) does not exceed 92mm, otherwise replace.
- 4 - Lubricate the screws copiously (H).
- 5 - Mount the cylinder head (L) and put in the screws (H).
- 6 - Tighten the screws in sequence (see diagram) to a temporary torque of 40 Nm.



If the screws (H) belong to 10.9 class, the tightening torque is 60Nm and it is not necessary to tighten them further.



Use a torque wrench with an angle torque tool to tighten the screws.

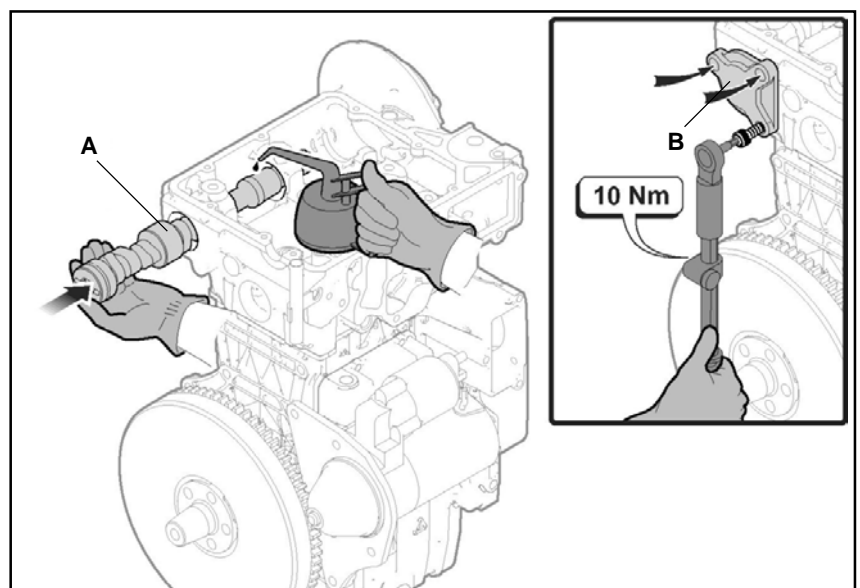
- 7 - Tighten the screws further clockwise, rotating 90°.
- 8 - Tighten the screws to their final torque, rotating 90°.

7.6.3 Assembling the camshaft



Make sure that the camshaft and its housing are perfectly intact and clean.

- 1 - Lubricate the camshaft (A) and its housing.
- 2 - Insert the camshaft into its housing.
- 3 - Mount a new O-ring onto the cover (B).
- 4 - Mount the cover (B) and tighten the screws to a torque of 10 Nm.

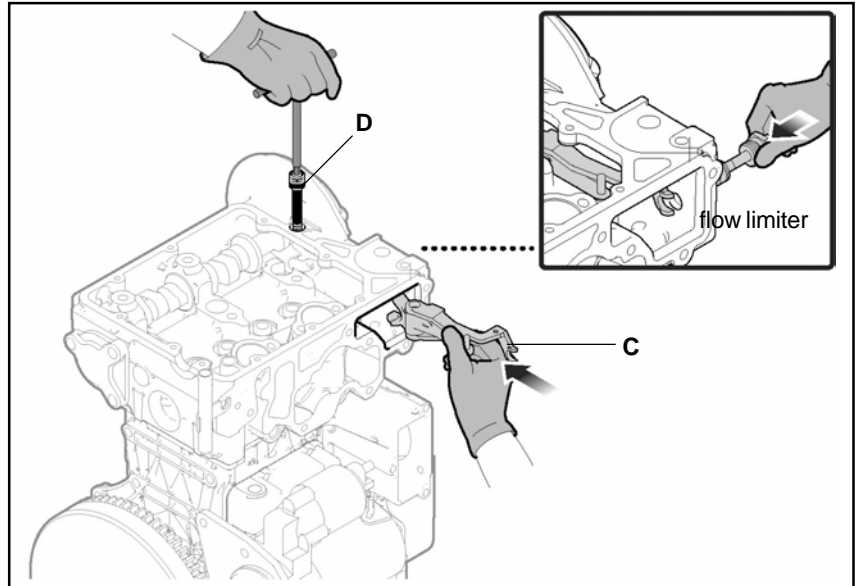


7.6.4 Assembling the speed governor and flow limiter

Important

- Make sure that all components are perfectly clean and dry.
- Check that all components are intact and, if necessary, replace them with original spares.

- 1 - Mount the levers (C) and pivot them with the screw (D) to a torque of 0.70 Nm.
- 2 - Install the flow limiter.

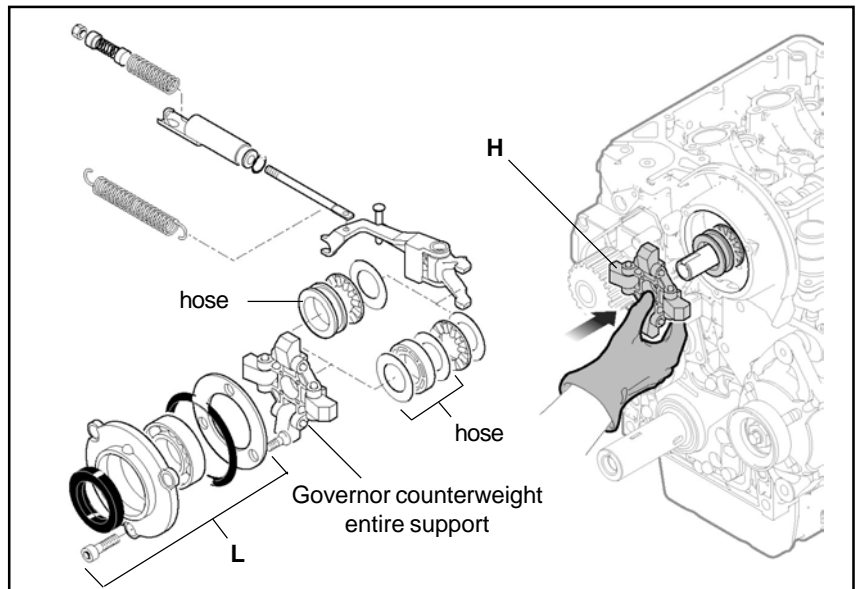


- 3 - Mount the rotation components onto the camshaft.

Important

The rotation components are produced in several versions. Consult the diagram when mounting.

- 1 - Mount the weights assembly (H) onto the camshaft. Carry out this operation with the weights open so that they close on the flat part of the spacing collar.
- 2 - Check that all the components of the cover (L) are intact and, if necessary, replace them with original spares.



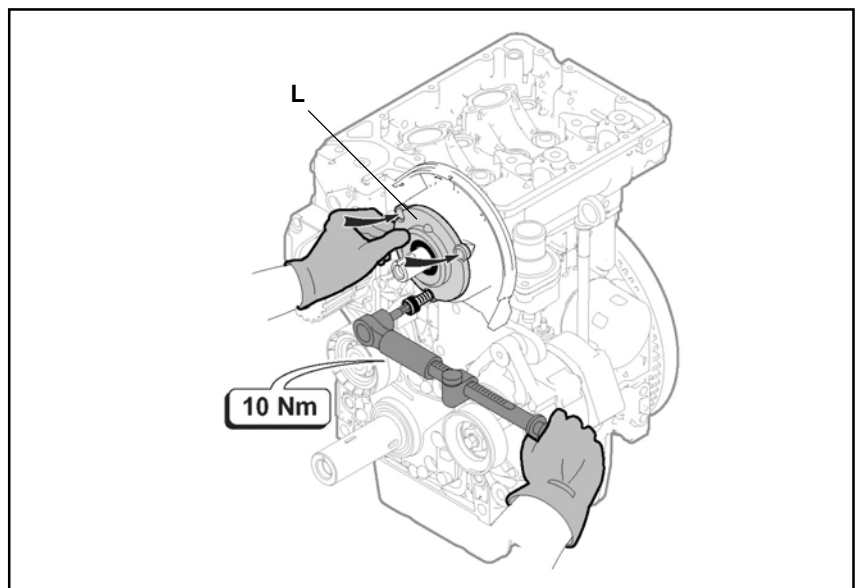
Important

Make sure that the contact surfaces are perfectly intact and clean.

- 3 - Mount the new O-ring on the cover (L).
- 4 - Mount the cover (L) and fasten the screws without tightening them.
- 5 - Tighten the screws in an alternating pattern to a final torque of 10 Nm.

Important

Check that the camshaft has no axial clearance.

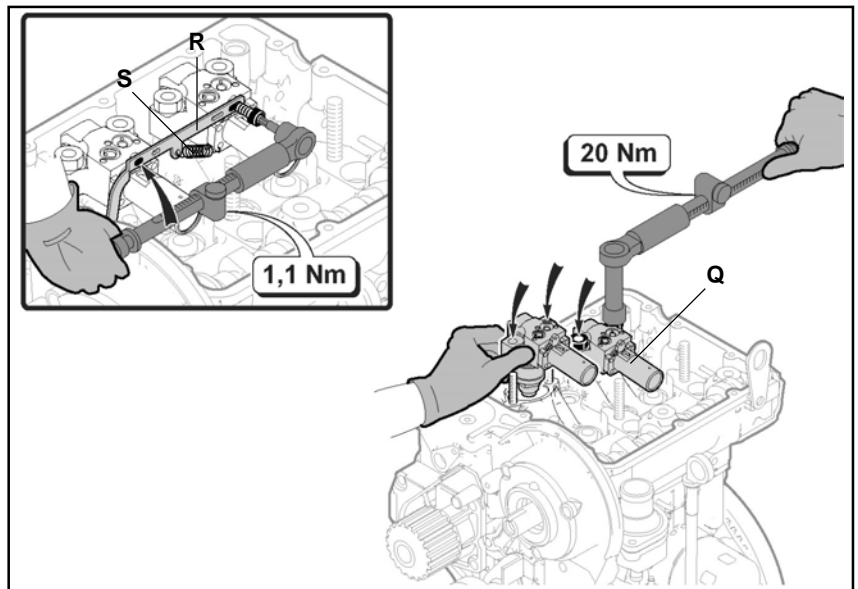
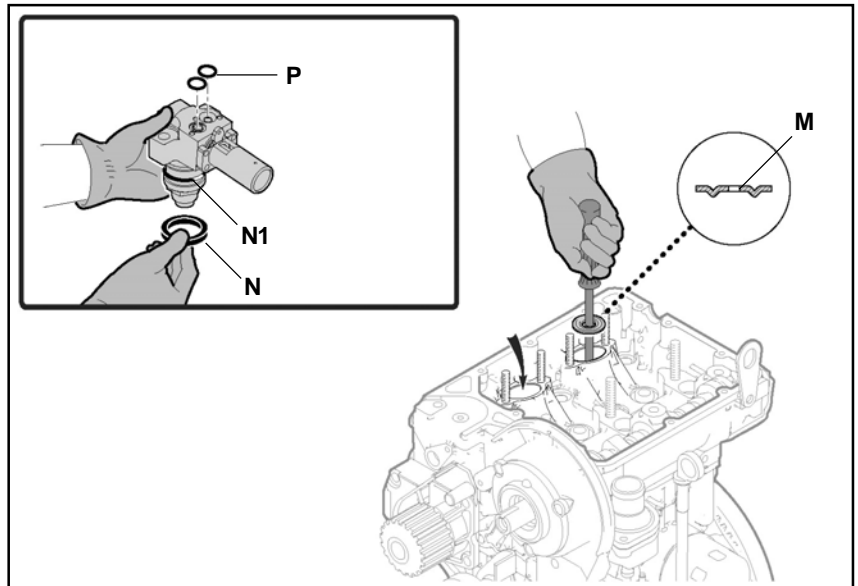


7.6.5 Assembling injection-pumps

Important

- Check that all components are intact and, if necessary, replace them with original spares.
- Before replacing the injectors it is always necessary to replace the flameproof bulkhead, the copper gasket and the oil and diesel O-ring seals.
- Always make sure that the injectors are calibrated correctly (see "Calibrating and replacing the injector").

- 1 - Insert the flameproof bulkhead (M) in the injector seat, with the flat part directed as in the drawing.
- 2 - Grease the copper gasket (N) and the oil O-ring seals (N1) copiously.
- 3 - Install the injector pumps (Q) and fasten the nuts without tightening them.
- 4 - Tighten the nuts to a temporary torque of 10 Nm.
- 5 - Tighten the nuts to a final torque of 20 Nm.
- 6 - Hook the connecting rod (R) to the adjustment levers and, fasten the injector pumps without fully tightening the screws.
- 7 - Tighten the screws to a final torque of 1,1 Nm.
- 8 - Hook the spring (S).

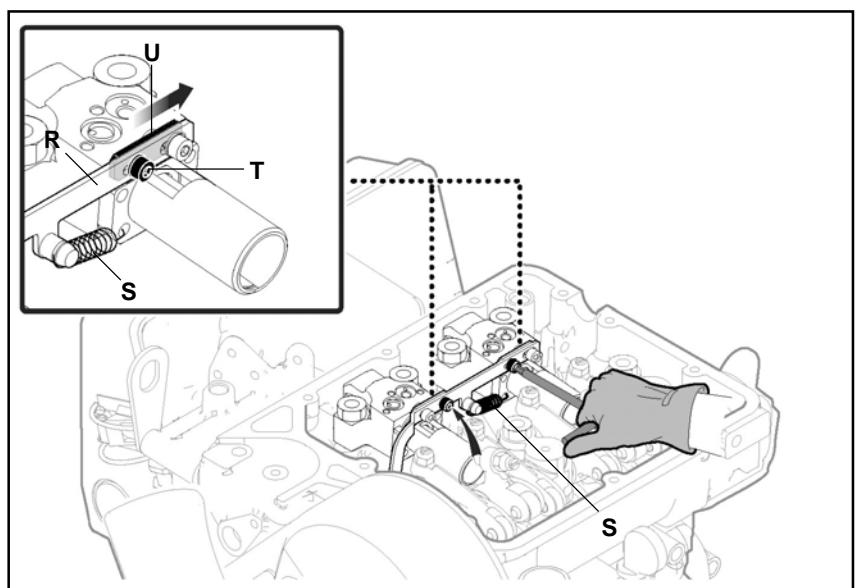


Important

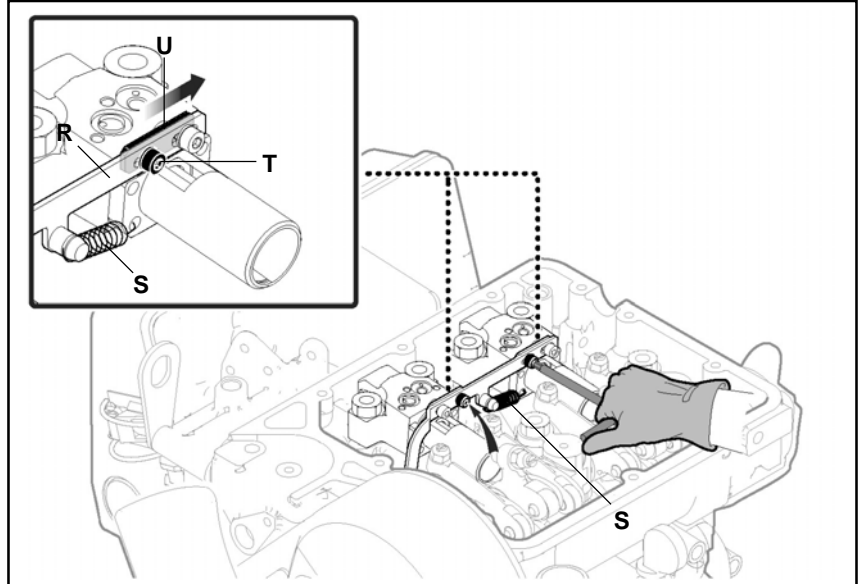
The following procedures must be performed only if pumps have been replaced. Otherwise, go directly to point 13.

Prepare the injector pumps for running the engine, as explained below.

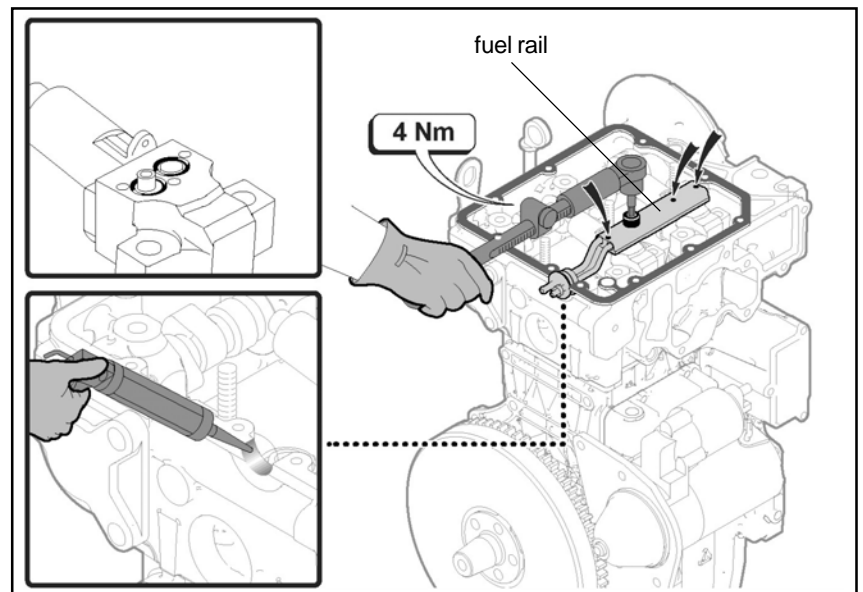
- 9 - Loosen the screws (T) of every injection pump.
- 10 - Move the plates (U) fully towards the flywheel side in order to maximise the injector delivery.



- 11 - Tighten the screws (**T**) to a torque of 1,1 Nm.
- 12 - Balance the injector deliveries (see "Balancing injector pump deliveries").



- 13 - Put the new O-rings on the injector pumps.
- 14 - Apply sealant to the seat of the fuel rail.
- 15 - Assemble the fuel rail and fasten the screws without tightening them.
- 16 - Tighten the screws to a final torque of 4Nm.
- 17 - Mount the rocker arm cover (see "Assembling the rocker arm cover").

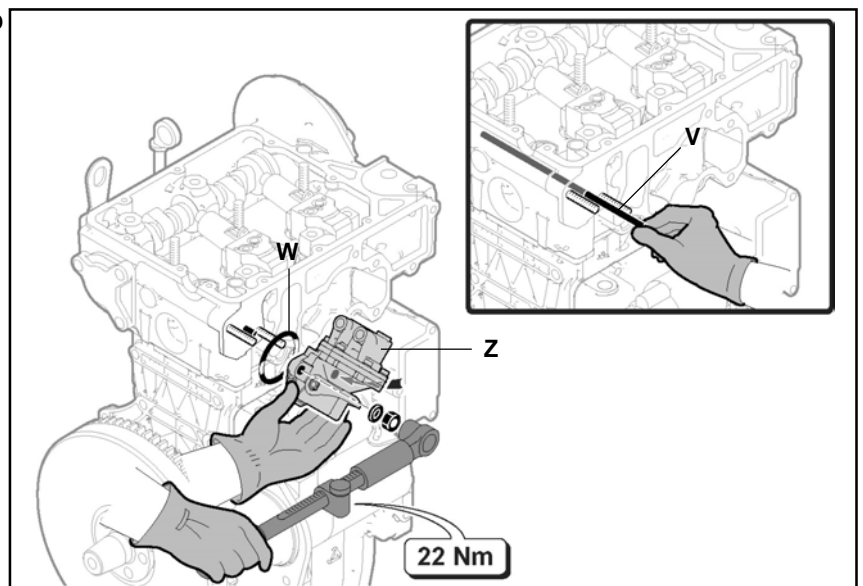


7.6.6 Assembling the mechanical fuel pump



- Check that the contact surfaces are perfectly clean and intact.
- Make sure that the length of the drive rod is between 153,15÷153,25 mm, otherwise replace it.

- 1 - Insert the drive rod (**V**).
- 2 - Mount a new O-ring (**W**).
- 3 - Install the fuel pump (**Z**) and fasten the nuts without tightening them.
- 4 - Tighten the nuts to a final torque of 22Nm.
- 5 - Connect the pipes to the pump.

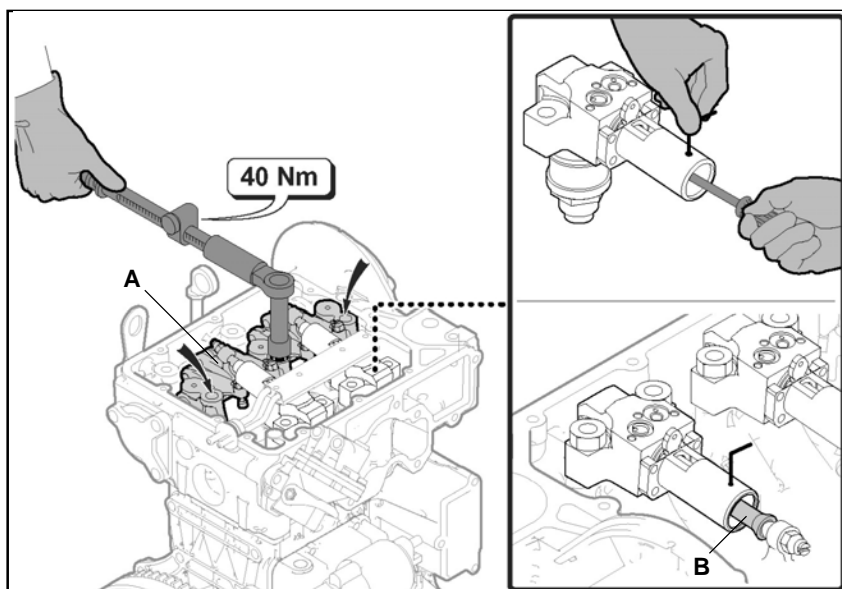


7.6.7 Assembling the rocker arms



Check that the contact surfaces are perfectly clean and intact.

- 1 - Press down hard on the pump stroke to insert the pin, which facilitates assembly of the drive rods (B).
- 2 - Mount the rocker arm assembly (A).
- 3 - Insert the pump injector activation drive rods (B).
- 4 - Tighten the nuts by hand.
- 5 - Tighten the nuts to a temporary torque of 20 Nm.
- 6 - Tighten the screws in an alternating pattern to a final torque of 40 Nm.
- 7 - Remove the pins and check that the rocker arms (B) have been inserted correctly.

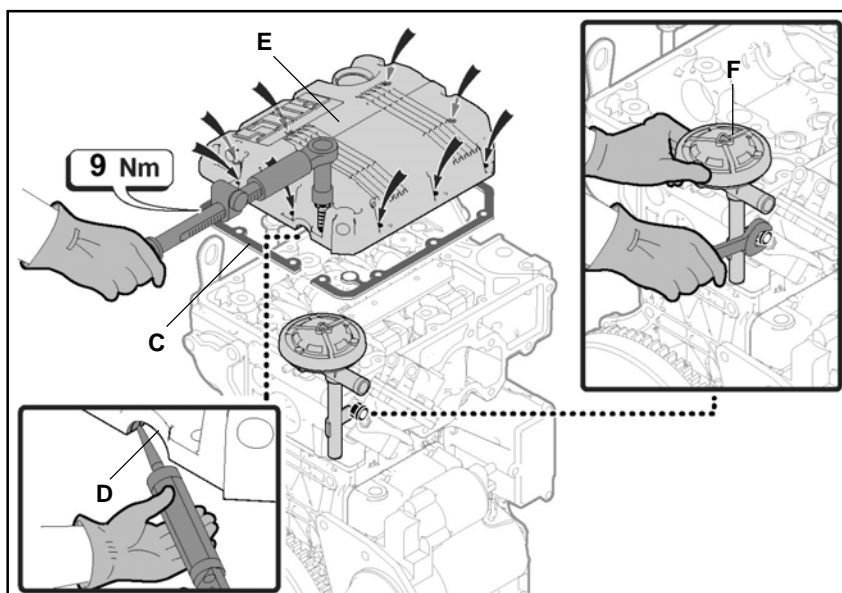


7.6.8 Assembling the rocker arm cover



- **Make sure that the rocker arm cover is perfectly clean and dry.**
- **Check that the contact surfaces are perfectly clean and intact.**

- 1 - Slip on a new gasket (C).
- 2 - Apply some silicone sealant on the fuel rail seat (D).
- 3 - Mount the cover (E) and fasten the screws without tightening them.
- 4 - Tighten the screws in a crisscross pattern to a final torque of 9 Nm.
- 5 - Assemble the negative-pressure vent valve (F).



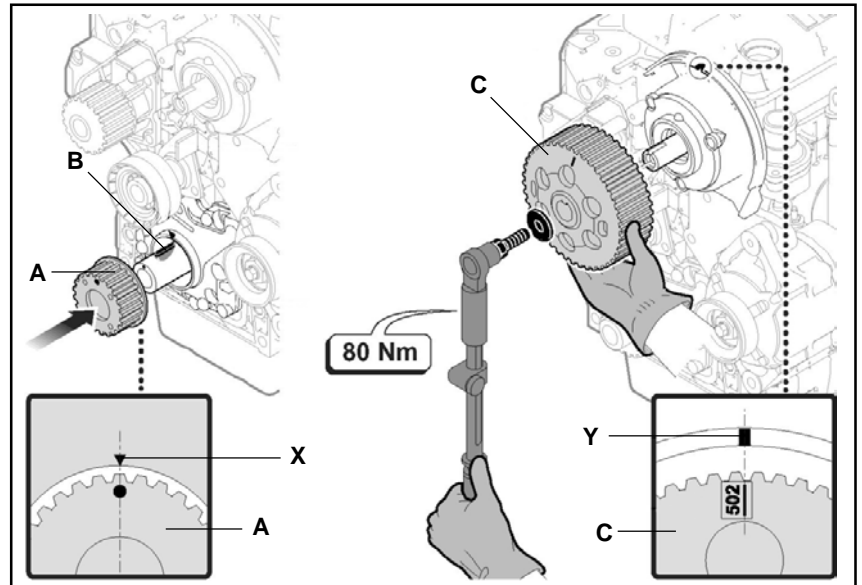
7.7 INSTALLING THE TIMING BELT DRIVE

7.7.1 Assembling the timing belt pulley

- 1 - Insert the key (B) into the crankshaft.
- 2 - Mount the pulley (A).
- 3 - Mount the pulley (C) and tighten the screw to a torque 80 Nm.



To ensure the correct timing, line up the reference notches on the pulley (A-C) with the respective gear timing notches (X-Y).



7.7.2 Assembling the timing belt

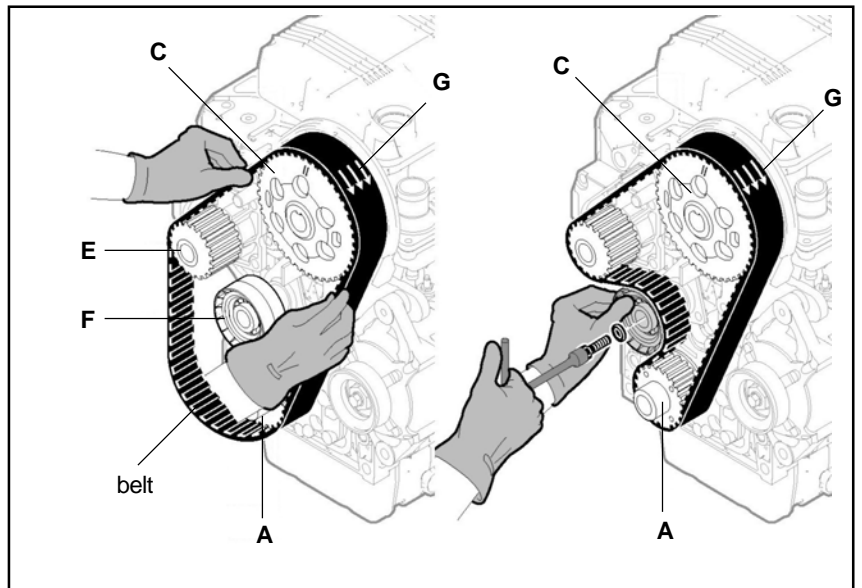
- 1 - Insert the belt into the pulley (C). Keeping it taut, insert into pulley (A).



- Keep the reference arrows (G) directed as shown in the diagram.
- The timing belt must always be replaced with an original spare part whenever it is removed.

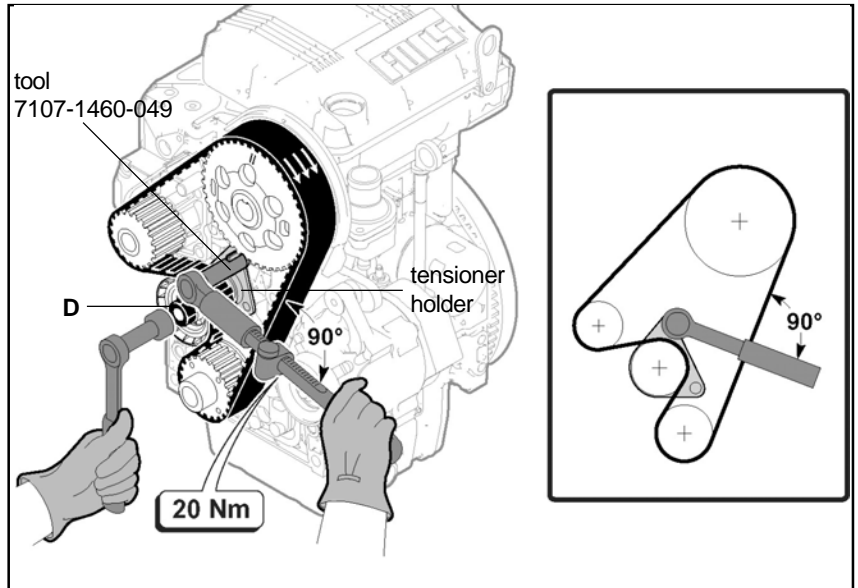
- 2 - Keep the belt inserted into the two pulleys and then mount it onto pulley (E) and the pulley nut (F).

- 3 - Tighten the belt using the pulley nut (F) and fasten temporarily.

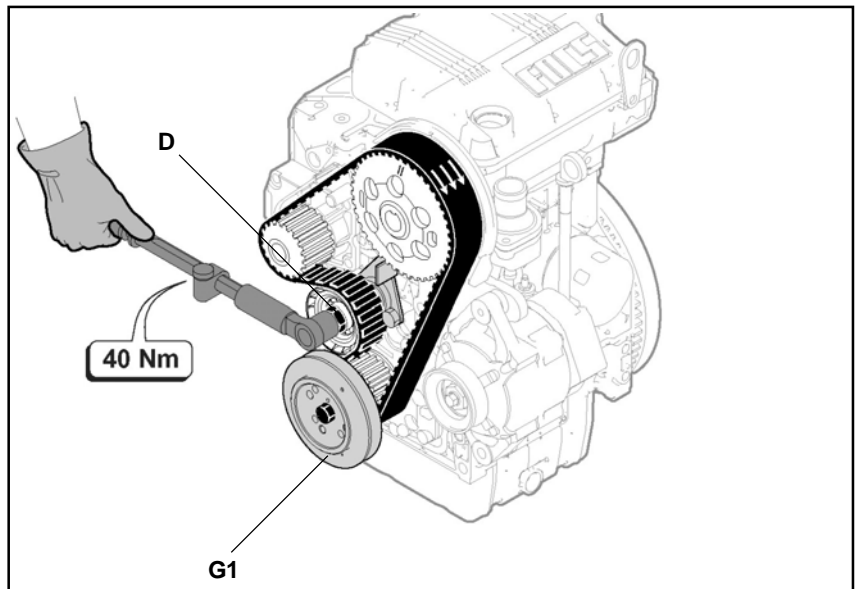


To maintain engine timing while the timing belt is being installed, keep it slotted onto the two pulleys (A-C), which must remain lined up with their notches.

- 4 - Insert tool "7107-1460-049" in the tensioner holder lever.
- 5 - Calibrate the torque wrench to 20 Nm and insert it into the tool, with the lever perpendicular to the belt.
- 6 - Loosen the nut slightly (D).
- 7 - Turn the torque wrench clockwise to tighten the belt to 20 Nm. Once the specified torque is reached (20 Nm), tighten the nut (D) temporarily without allowing the belt tension to loose.



- 8 - Mount the pulley (G1).
- 9 - Tighten the nut (D) to a final torque of 40Nm.
- 10 - Rotate the crankshaft a few times to settle and position the belt correctly.
- 11 - Before doing so, make sure that the pulley notches (crankshaft and camshaft) are lined up with their respective timing notches.
- 12 - Insert the tool again into the lever on the pulley nut support and repeat all the steps to check belt tension.
- 13 - Disassemble the pulley (G1).

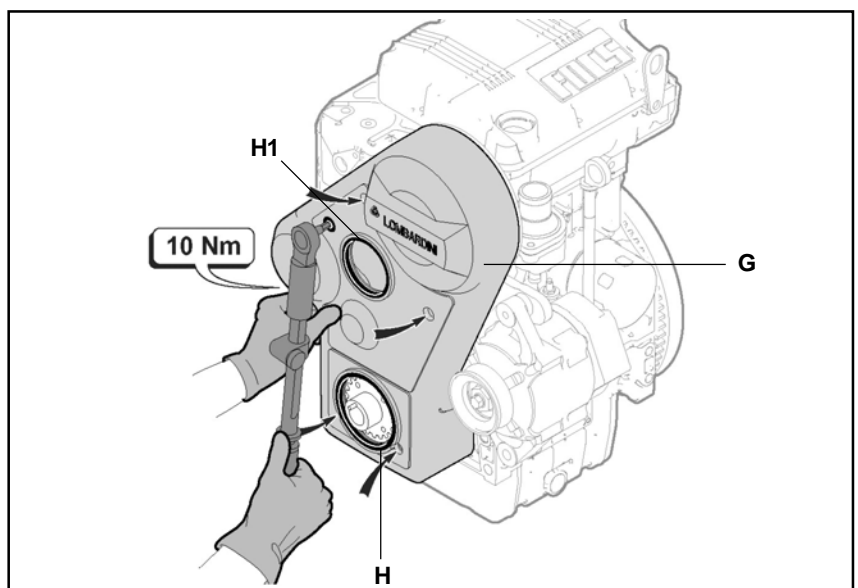


7.7.3 Assembling the belt drive cover

- 1 - Mount the guard (G), without tightening the screws completely.
- 2 - Tighten the screws in an alternating pattern to a final torque of 10 Nm.

Important

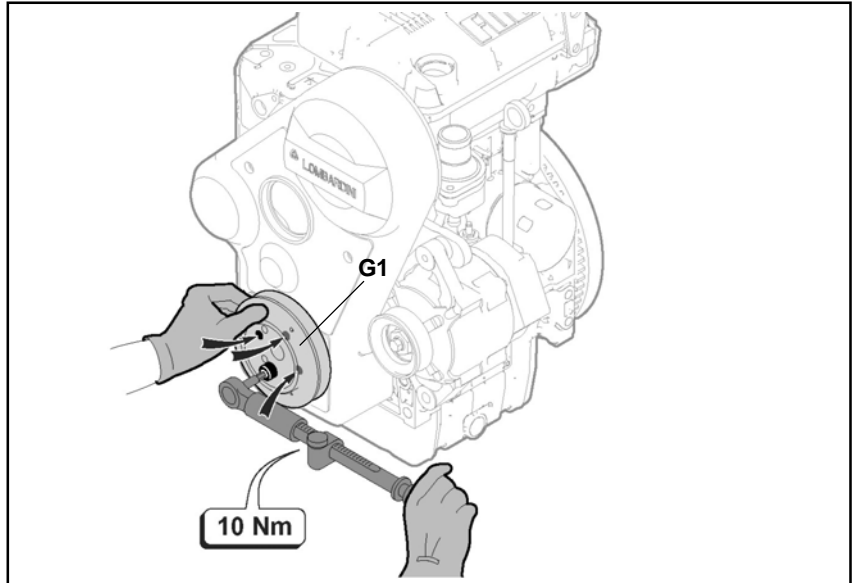
If replacement of the optional dust guard rings (H-H1) and the peripheral sleeve becomes necessary for technical or construction reasons, please request the pre-assembled guard (G) complete with rings and gaskets.



7.8 INSTALLATION OF THE COOLING FAN BELT DRIVE

7.8.1 Assembling the fan belt drive pulleys

- 1 - Check that all components are intact and, if necessary, replace them with original spares.
- 2 - Mount the pulley (**G1**) and fasten the screws without tightening them.
- 3 - Tighten the screws in a crisscross pattern to a final torque of 10 Nm.



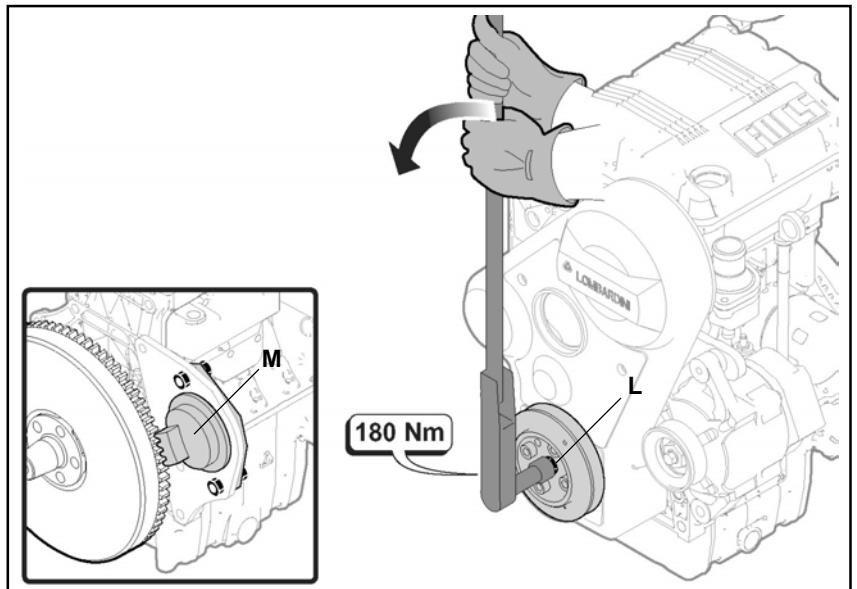
- 4 - Mount tool “7107-1460-051” to inhibit rotation of the crankshaft.
- 5 - Apply some anti-seize product to the screw thread (**L**).



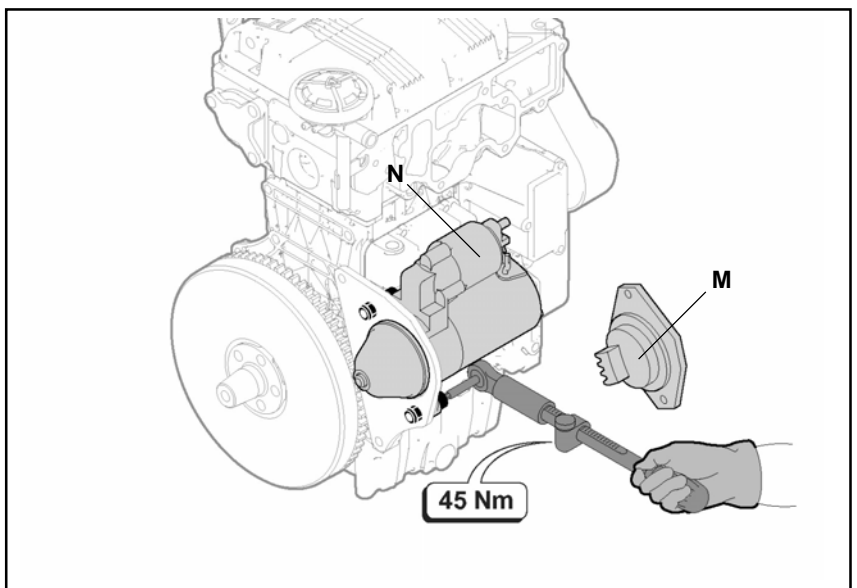
Caution - Warning

The screw is left-handed. Turn anticlockwise to screw.

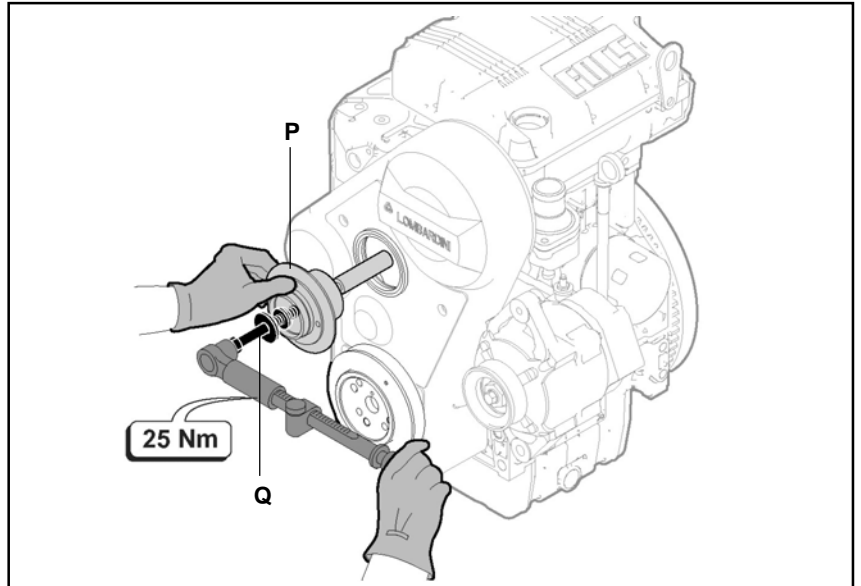
- 6 - Tighten the screw (**L**) to a torque of 180 Nm.



- 7 - Remove the tool (**M**).
- 8 - Install the starter motor (**N**) and tighten the screws to a torque of 45 Nm.



- 9 - Mount the pulley (P), washers and spacer.
- 10 - Tighten the screw (Q) to a torque of 25 Nm.

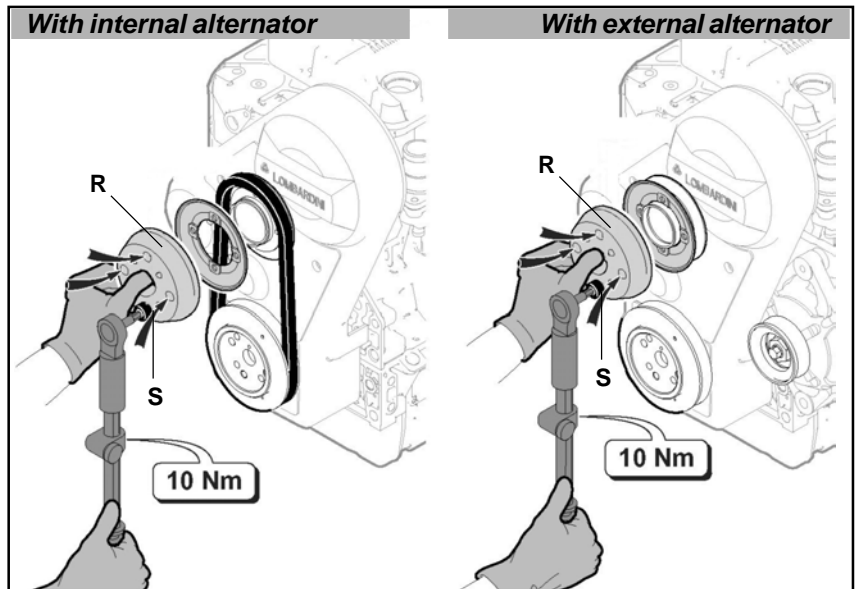


7.8.2 Assembling the fan belt drive

The engine may have an external or internal alternator.

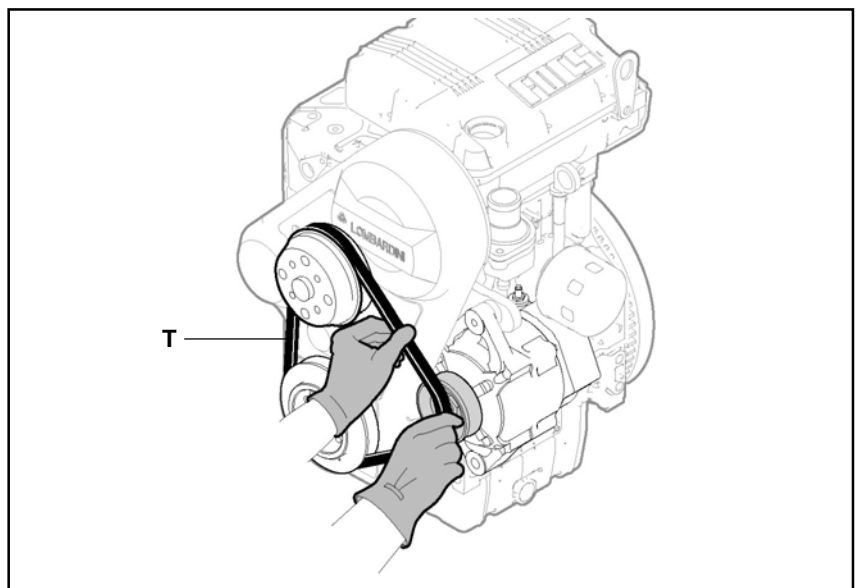
With internal alternator

- 1 - Install the belt, flange and the pulley hub (R).
- 2 - Tighten the screws (S) to a torque of 10 Nm.
- 3 - Carry out belt tension (see “Replacing alternator/fan belt”).



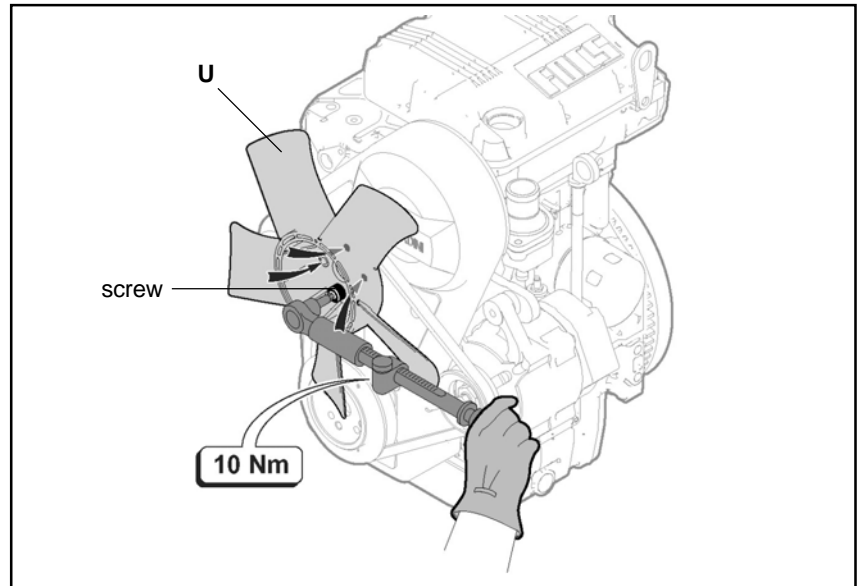
With external alternator

- 1 - Install the flange and the pulley hub (R).
- 2 - Tighten the screws (S) to a torque of 10 Nm.
- 3 - Install the belt (T).
- 4 - Tighten the belt (T) (see “Replacing the alternator – fan belt”).



7.8.3 Assembling the cooling fan

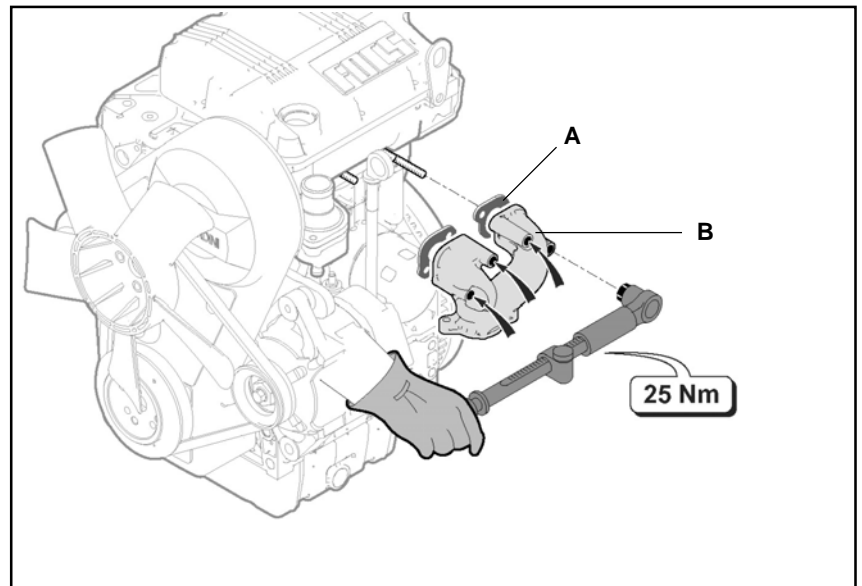
- 1 - Check that the fan is intact and, if necessary, replace it with an original spare.
- 2 - Install the cooling fan (**U**).
- 3 - Tighten the screws to a torque of 10 Nm.



7.9 INSTALLING INTAKE AND EXHAUST MANIFOLDS

7.9.1 Assembling exhaust manifold

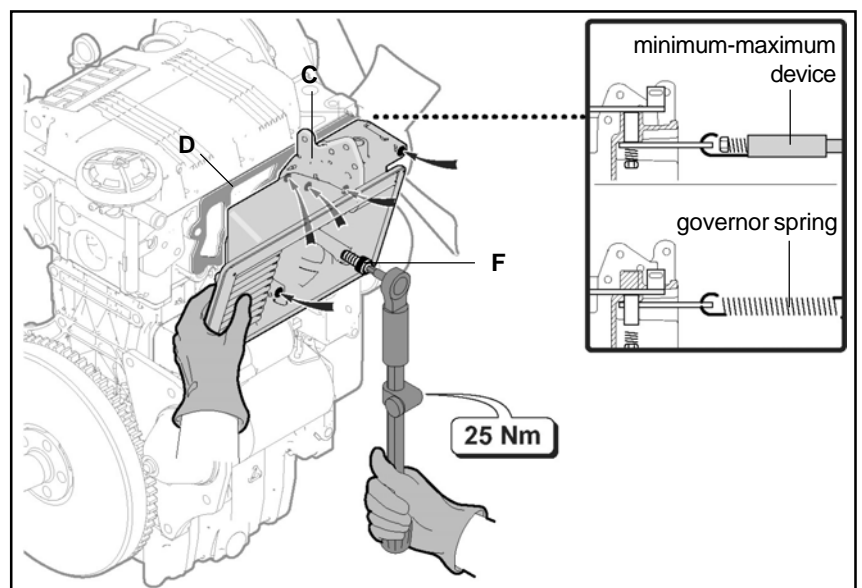
- 1 - Make sure that the manifold ducts are clean and intact.
- 2 - Check that the contact surfaces are perfectly clean and intact.
- 3 - Eliminate any blockages in the ducts.
- 4 - Put on the new gaskets (**A**).
- 5 - Mount the manifold (**B**) without tightening the nuts completely.
- 6 - Tighten the screws in an alternating pattern to a final torque of 25 Nm.



7.9.2 Assembling the intake manifold

Air filter (square type)

- 1 - Check that the contact surfaces are perfectly clean and intact.
- 2 - Eliminate any blockages in the ducts.
- 3 - Slip on a new gasket (**D**).
- 4 - Bring the manifold (**C**) up to the cylinder head and hook on the minimum-maximum device or the governor spring.
- 5 - Install the manifold (**C**) without tightening the screws (**F**) completely.
- 6 - Tighten the screws in an alternating pattern to a final torque of 25 Nm.



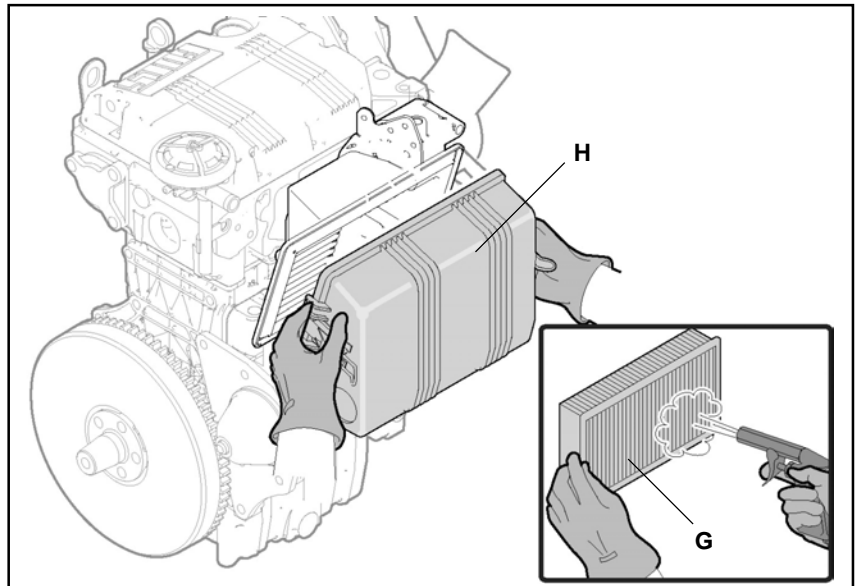
- 7 - Clean the cover (**H**) with a jet of air.
- 8 - Check the state of the filter cartridge (**G**). If necessary, remove the cartridge, knock it repeatedly against a flat surface to eliminate dirt and clean with a jet of air.
- 9 - Return the cleaned filter cartridge or replace it with an original spare.



Caution - Warning

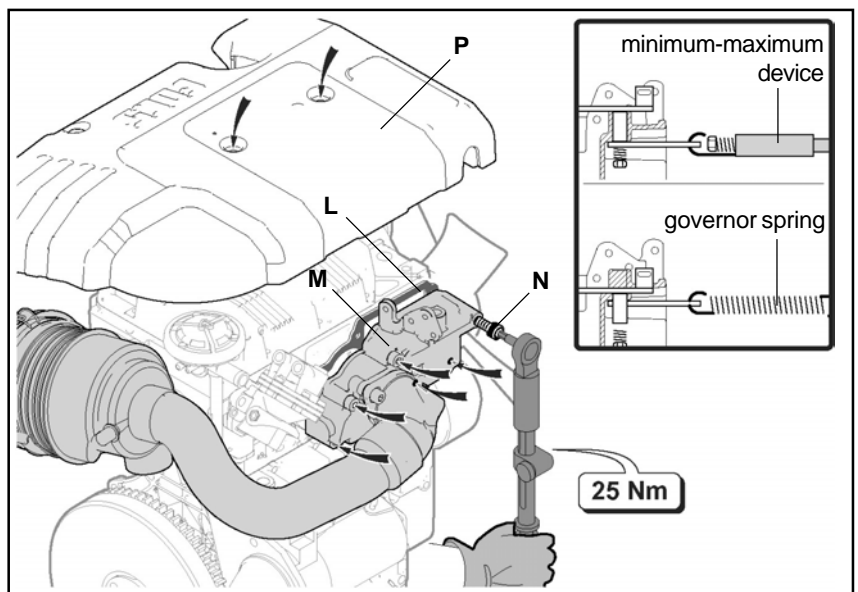
Do not use liquids to clean the filter cartridge.

- 10 - Replace the cover (**H**) and re-hook it carefully into place.



Air filter (cylindrical type)

- 1 - Check that the contact surfaces are perfectly clean and intact.
- 2 - Eliminate any blockages in the ducts.
- 3 - Slip on a new gasket (**L**).
- 4 - Bring the manifold (**M**) up to the cylinder head and hook on the minimum-maximum device.
- 5 - Install the manifold (**M**) without tightening the screws (**N**) completely.
- 6 - Tighten the screws in an alternating pattern to a final torque of 25Nm.
- 7 - Check the state of the filter cartridge. If necessary, remove the cartridge and clean with a jet of air.
- 8 - Return the cleaned filter cartridge or replace it with an original spare.



Caution - Warning

Do not use liquids to clean the filter cartridge.

- 9 - Replace the filter housing.
- 10 - Mount the cover (**P**).

8.1 RACCOMMENDATIONS FOR REPLACING PARTS

- This chapter describes the procedures for replacing a number of components and/or assemblies which are not recommended for repairs.
- Some of these operations are also contained in the user's operation and maintenance manual.
- Before any intervention, the operator should lay out all equipment and tools in such a way as to enable him to carry out operations correctly and safely.
- Before proceeding with operations, make sure that appropriate safety conditions are in place, in order to safeguard the operator and any persons involved.

- All operations, except where expressly stated otherwise, must be carried out when the engine is not running and has cooled sufficiently to avoid the risk of burns.



Important

To locate specific topics, the reader should refer to the index.

8.2 REPLACING THE ALTERNATOR - FAN BELT



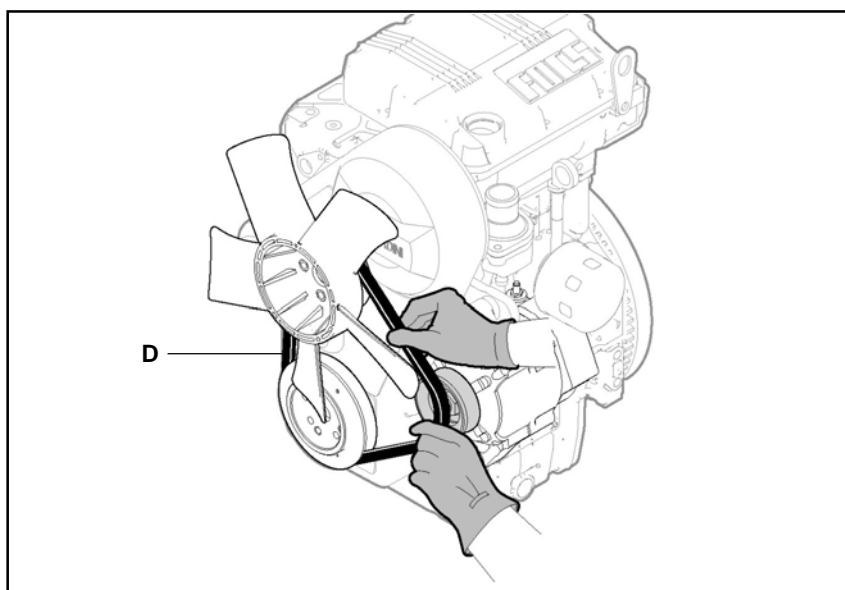
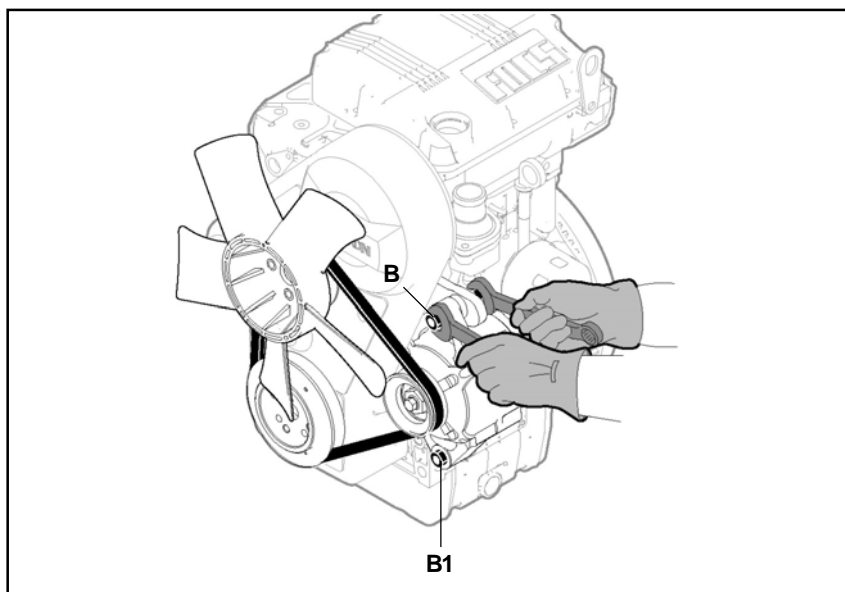
Important

Replacement may be carried out with the engine installed on the machine.

The engine may have an external or internal alternator.

With external alternator

- 1 - Switch off the engine and leave to cool.
- 2 - Loosen the nuts (**B - B1**).
- 3 - Loosen the belt by adjusting the alternator manually and tighten the nut (**B1**).
- 4 - Slip off the belt (**D**) and replace it with an original spare.

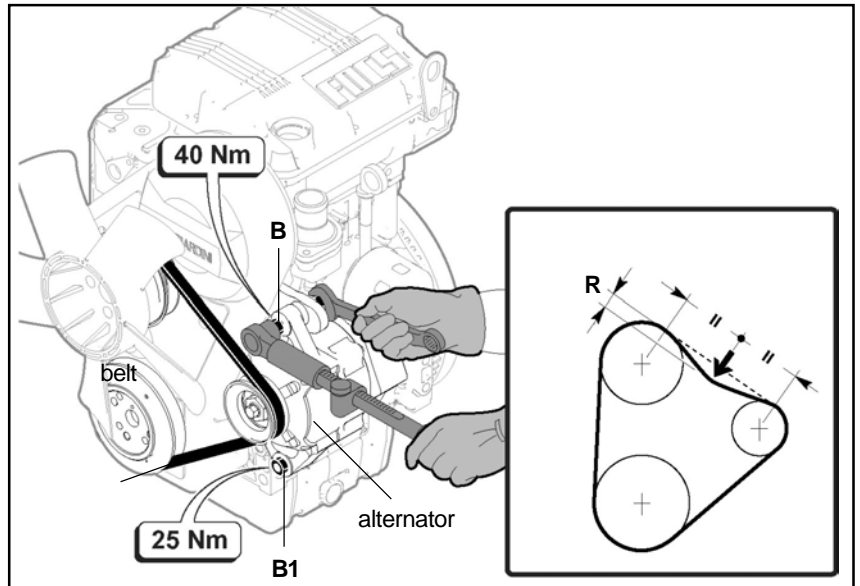


- 5 - Adjust the alternator manually while at the same time tightening the screw to regulate belt tension.

Important

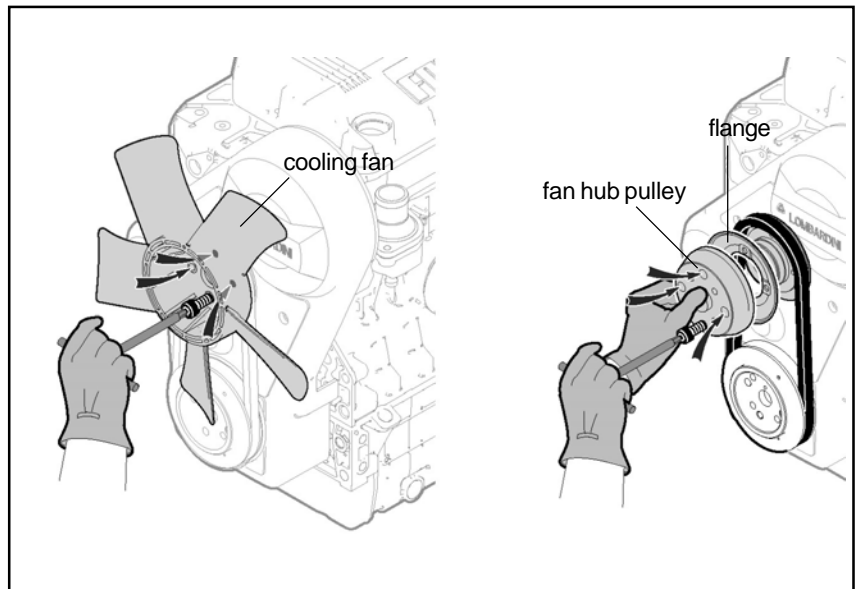
Use the method shown in the diagram to check belt tension. The resultant (R) must be 10÷15 mm.

- 6 - Tighten the nuts (B -B1) to a final torque of 40 Nm and 25 Nm respectively.



With internal alternator

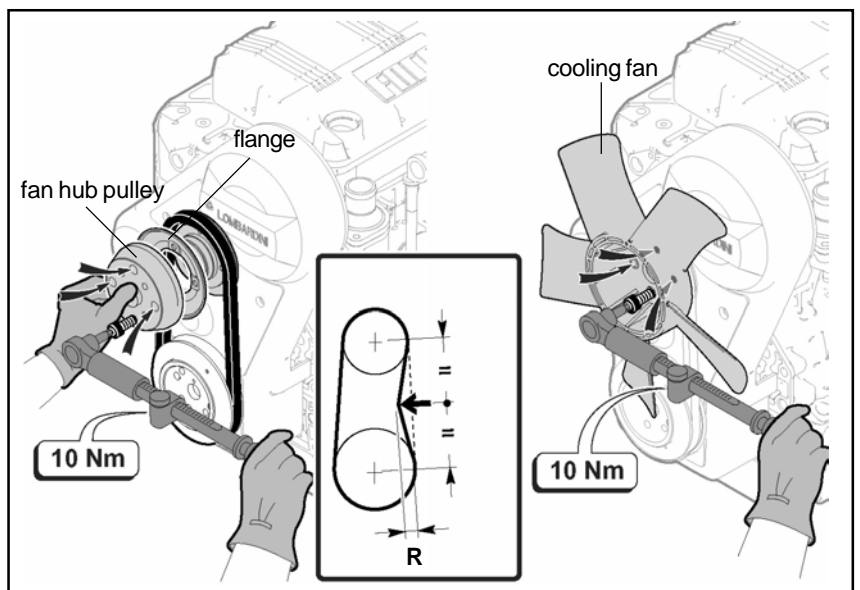
- 1 - Switch off the engine and leave to cool.
- 2 - Remove the cooling fan.
- 3 - Remove the hub and flange.
- 4 - Slip off the belt and replace it with an original spare.



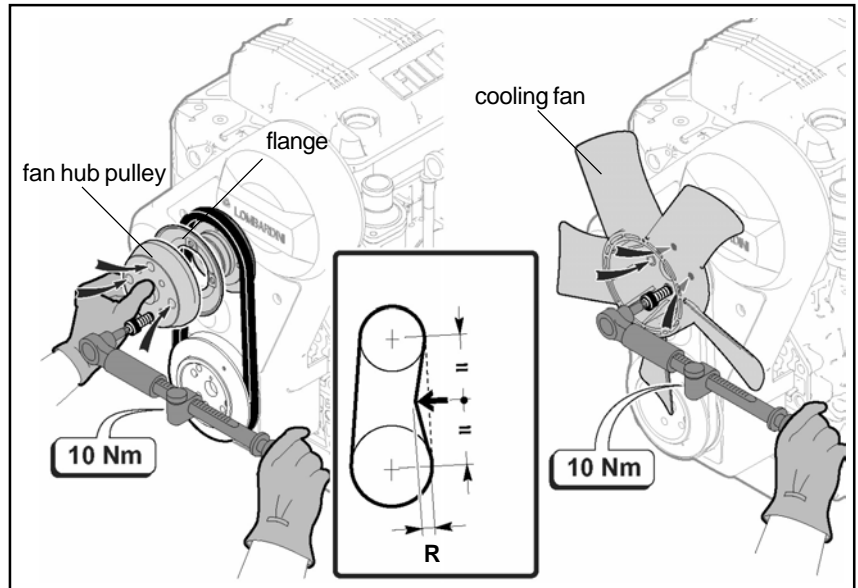
- 5 - Install the flange and pulley hub.
- 6 - Manually rotate the fan to make sure the belt is fitted correctly.
- 7 - Tighten the screws to a torque of 10 Nm.
- 8 - Regolare la tensione della cinghia.

Important

- To check the belt tension, follow the procedure explained in the figure. The resultant (R) must be 10÷15 mm.
- If the belt is too tense, insert a spacer between the flange and the pulley, or remove a spacer if it is too slack.



- 9 - Install the cooling fan.
- 10 - Tighten the screws to a torque of 10 Nm.



8.3 REPLACING THE TIMING BELT

Important

Replacement may be carried out with the engine installed on the machine.

- 1 - Switch off the engine and leave to cool.
- 2 - Disassemble the cooling fan belt drive (see "Removing the cooling fan belt drive").
- 3 - Disassemble the timing belt drive (see "Removing the timing belt drive").
- 4 - Replace the timing belt with an original spare (see "Assembling the timing belt drive").
- 5 - Check the timing belt rating (see "Checking timing belt rating").
- 6 - Mount the belt drive cover (see "Assembling the belt drive cover").
- 7 - Replace the cooling fan belt drive (see "Installation of the cooling fan belt drive").

8.4 REPLACING THE OIL FILTER

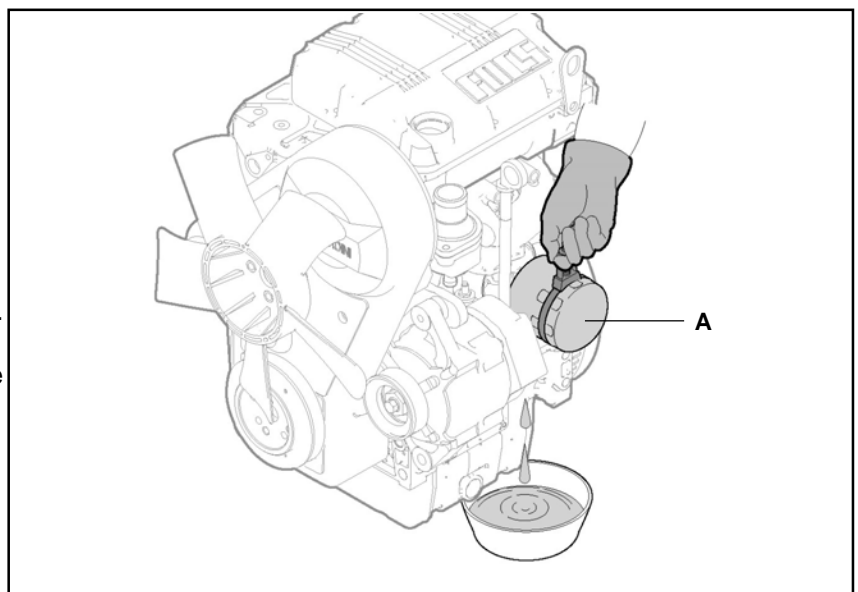
Important

Replacement may be carried out with the engine installed on the machine.

- 1 - Switch off the engine and leave to cool.
- 2 - Prepare a receptacle to catch leaks.
- 3 - Remove the filter (A) using the special tool.
- 4 - Lubricate the new filter seal with engine oil.
- 5 - Install and tighten the filter manually.

Important

Polluting substances should be disposed of properly, in full compliance with the law.



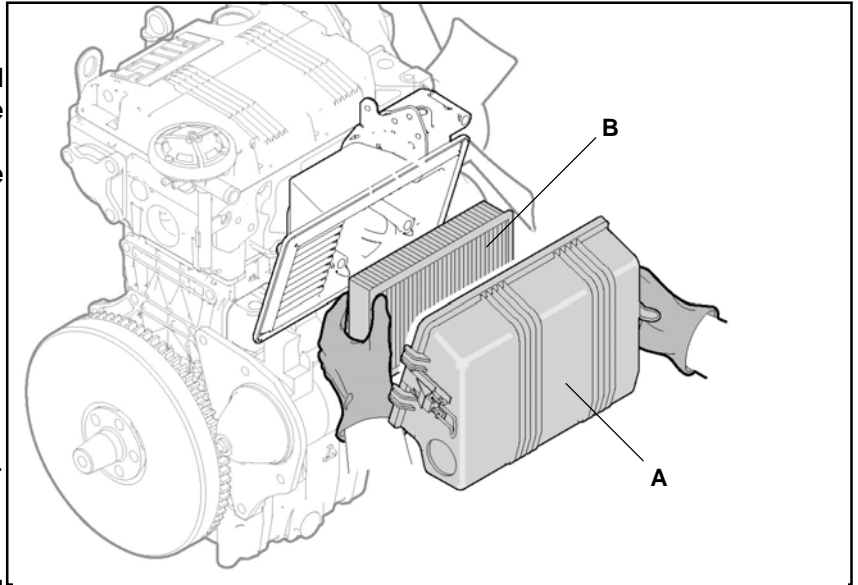
8.5 REPLACING THE AIR FILTER

Important

- Polluting substances should be disposed of properly, in full compliance with the law.
- Replacement may be carried out with the engine installed on the machine.

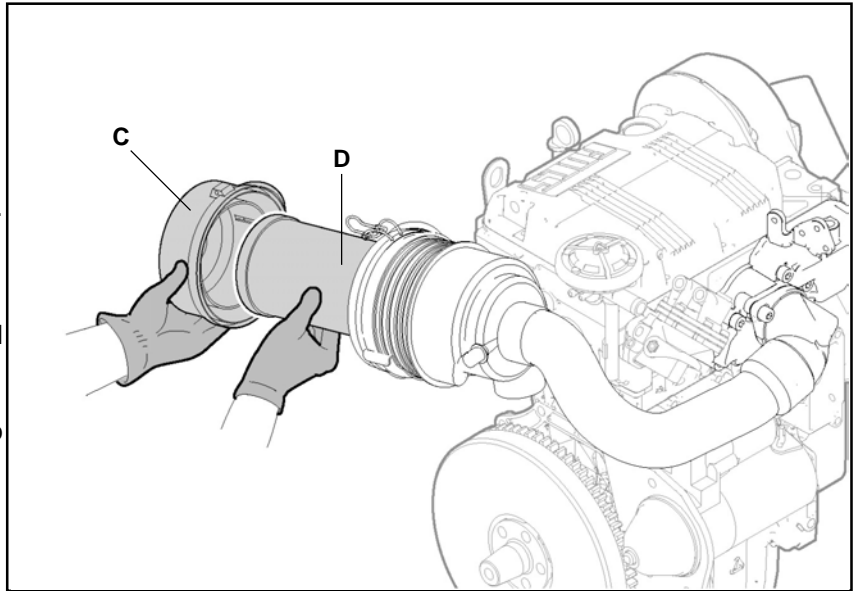
Air filter (square type)

- 1 - Switch off the engine and leave to cool.
- 2 - Remove the cover (A).
- 3 - Extract the cover that is to be replaced (B).
- 4 - Clean the cover with a jet of air.
- 5 - Replace the cartridge with an original spare.
- 6 - Mount the cover and hook it carefully into place.



Air filter (cylindrical type)

- 1 - Switch off the engine and leave to cool.
- 2 - Remove the cover (C).
- 3 - Extract the cover that is to be replaced (D).
- 4 - Clean the cover with a jet of air.
- 5 - Replace the cartridge with an original spare.
- 6 - Mount the cover and hook it carefully into place.



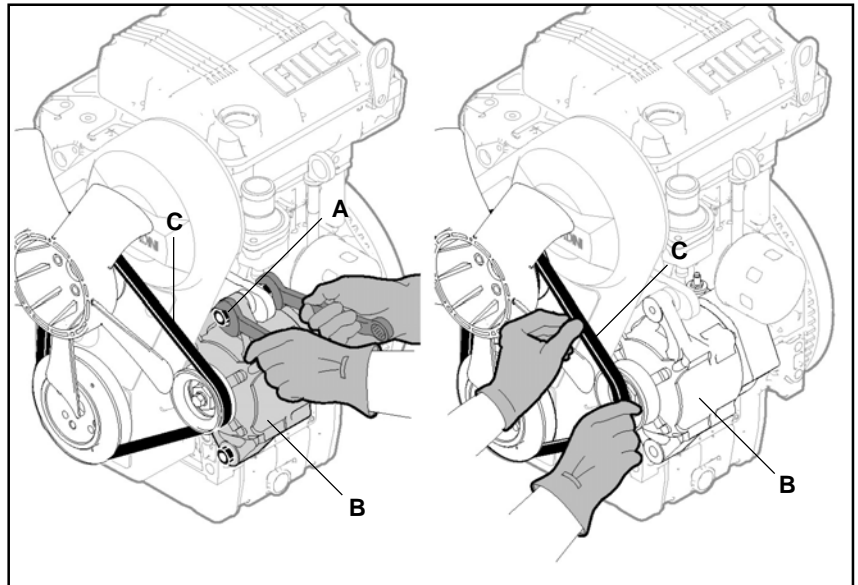
8.6 REPLACING THE ALTERNATOR



Caution - Warning

Replacement may be carried out with the engine installed on the machine.

- 1 - Switch off the engine and leave to cool.
- 2 - Disconnect the battery.
- 3 - Disconnect the electrical connectors.
- 4 - Loosen the nut (A).
- 5 - Loosen the belt (C) by adjusting the alternator (B) manually.
- 6 - Slip the belt (C) off the alternator pulley.
- 7 - Remove the alternator and replace it with a new one.
- 8 - Insert the belt into the alternator pulley.



9 - Regulate belt (C) tension (see “Replacing alternator – fan belt”).

10 - Reconnect the electrical connectors.

8.7 REPLACING THE STARTER MOTOR



Caution - Warning

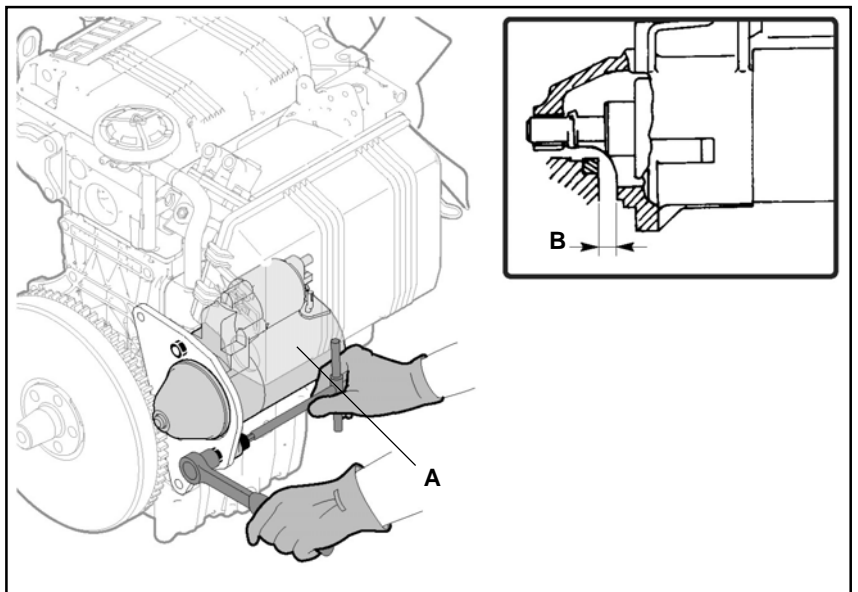
Replacement may be carried out with the engine installed on the machine.

- 1 - Switch off the engine and leave to cool.
- 2 - Disconnect the electrical connectors.
- 3 - Remove the starter motor.



Important

If in order to take care of the problem it is necessary to remove the motor, please refer to an authorised BOSCH service centre.



- 4 - Install the starter motor (A) and tighten the screws.
- 5 - Tighten the screws to a final torque of 40 Nm.
- 6 - Make sure that the distance (B) is between 17,5÷19,5 mm.
- 7 - Reconnect the electrical connectors.

8.8 REPLACING THE FLYWHEEL RING GEAR

In order to replace the ring gear, it is necessary to disassemble the flywheel.
See "Disassembling the flywheel" for the correct procedure.

- 1 - Cut the ring gear (A) in several places using a chisel and remove it.

Important

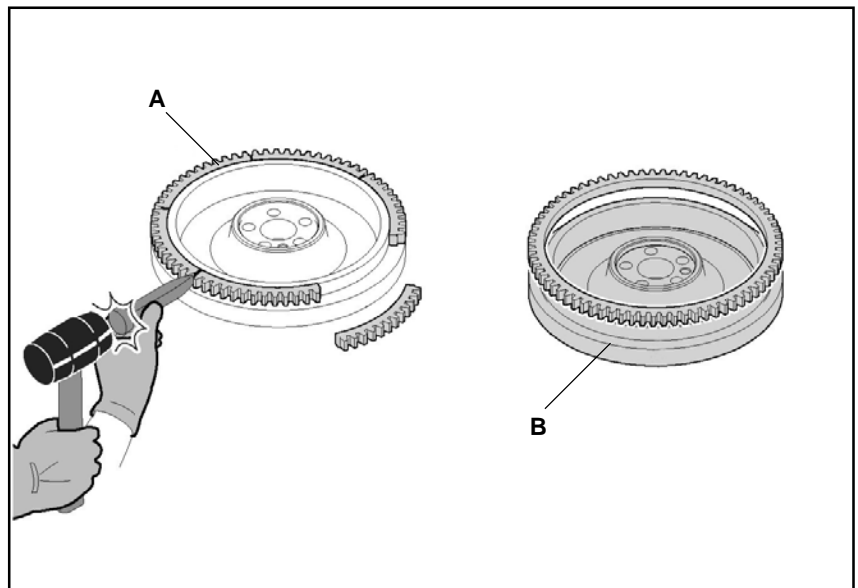
Remove any debris and carefully clean the ring gear.

- 2 - Heat the new ring gear uniformly and keep it at a temperature of 300°C for 15÷20 minuti.

Caution - Warning

Risk of burning: be careful of hot surfaces.

- 3 - Insert the ring gear into its seat and place it carefully on the rim of the flywheel (B).



- 4 - Leave to the ring gear to cool gently before reassembling the flywheel.

8.9 REPLACING THE COOLANT THERMOSTAT

Important

Replacement may be carried out with the engine installed on the machine.

- 1 - Switch off the engine and leave to cool.
- 2 - Disconnect the electrical connectors.
- 3 - Remove the thermostat.

Important

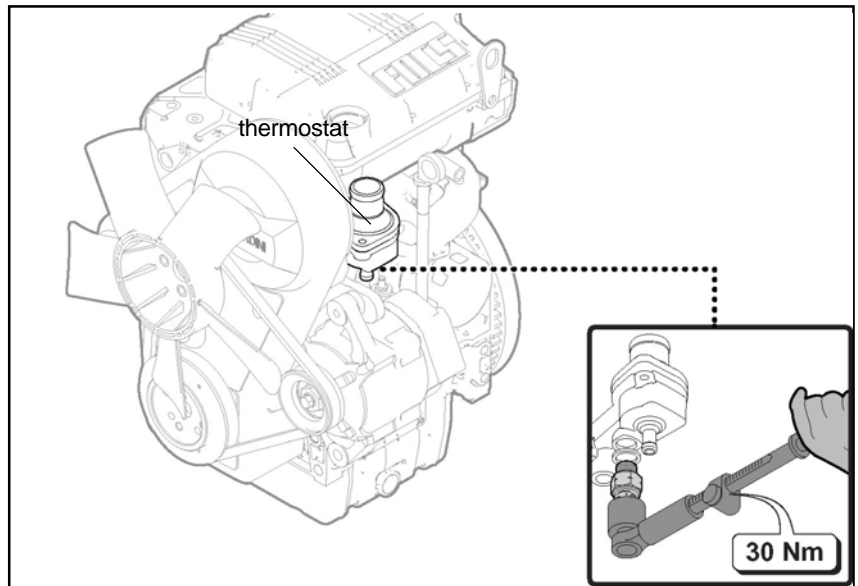
The screw is left-handed, turn clockwise to unscrew.

- 4 - Install the new thermostat.
- 5 - Tighten the thermostat to a torque of 30 Nm.

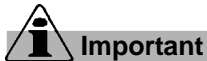
Important

The screw is left-handed, turn anti-clockwise to tighten.

- 6 - Reconnect the electrical connectors.



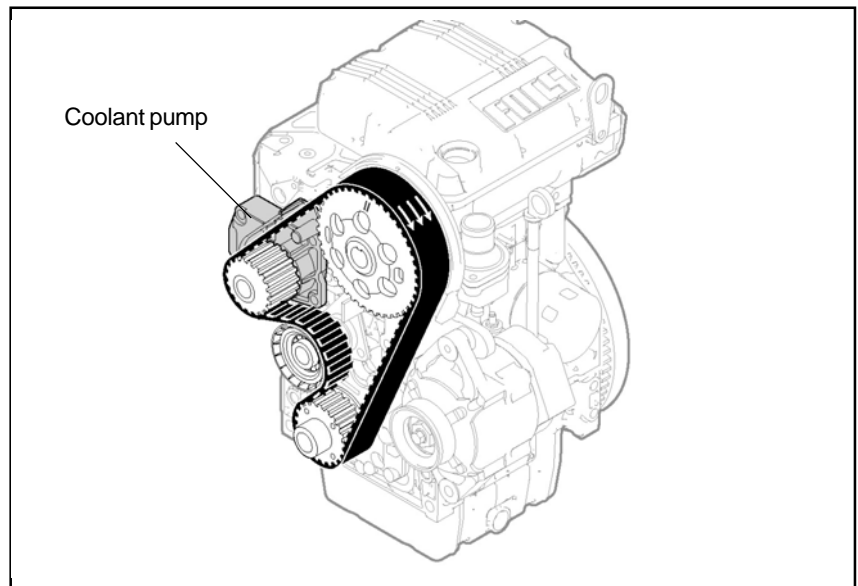
8.10 REPLACING THE COOLANT PUMP



Important

Replacement may be carried out with the engine installed on the machine.

- 1 - Switch off the engine and leave to cool.
- 2 - Disassemble the cooling fan (see "Removing the cooling fan belt drive").
- 3 - Disassemble the timing belt drive (see "Removing the timing belt drive").
- 4 - Disassemble the coolant pump.
- 5 - Install a new pump and tighten the screws to a torque of 20 Nm.



Important

Following a failure, the coolant pump cannot be repaired and must be replaced with an original spare.

8.11 REPLACING THE THERMOSTATIC VALVE



Important

Replacement may be carried out with the engine installed on the machine.

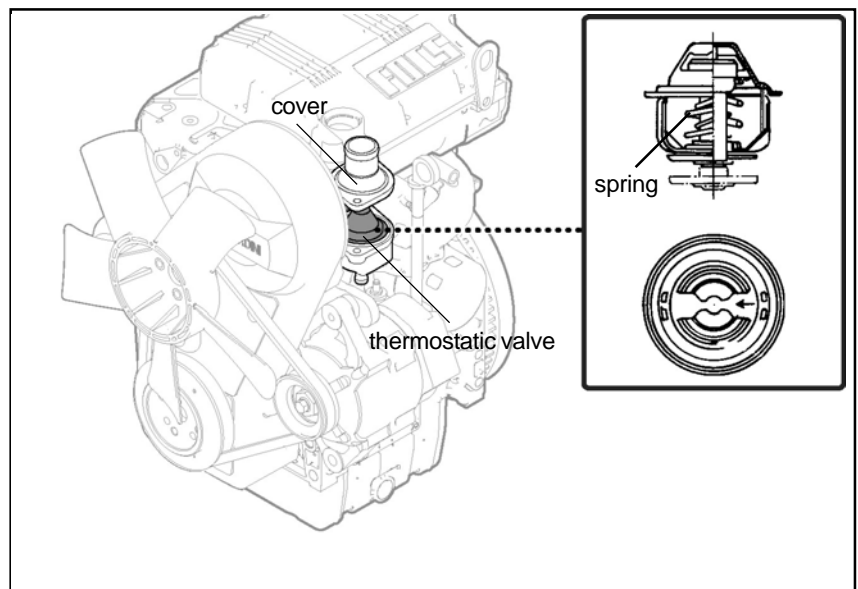
- 1 - Switch off the engine and leave to cool.
- 2 - Remove the cover.
- 3 - Remove the valve and make sure it is working properly.



Important

The valve must be heated in order to check whether it is functioning correctly.

- Dip the thermostatic valve in a metal container of water.
- Use a thermometer with a full scale of 150°C to monitor the temperature of the water in the container.
- Heat the water and, using the thermometer, make sure that the temperature at which the valve begins to open is between 78 and 82°C.
- If the thermostatic valve opens at a different temperature, it must be replaced.
- Maintaining the conditions described above, heat the water to 94°C and check whether or not the valve is completely open at this temperature, i.e. that it has lifted to 7mm.



- Check whether the valve is completely shut once it has cooled down.

If the length does not correspond to the value shown, replace the valve spring with an original spare.

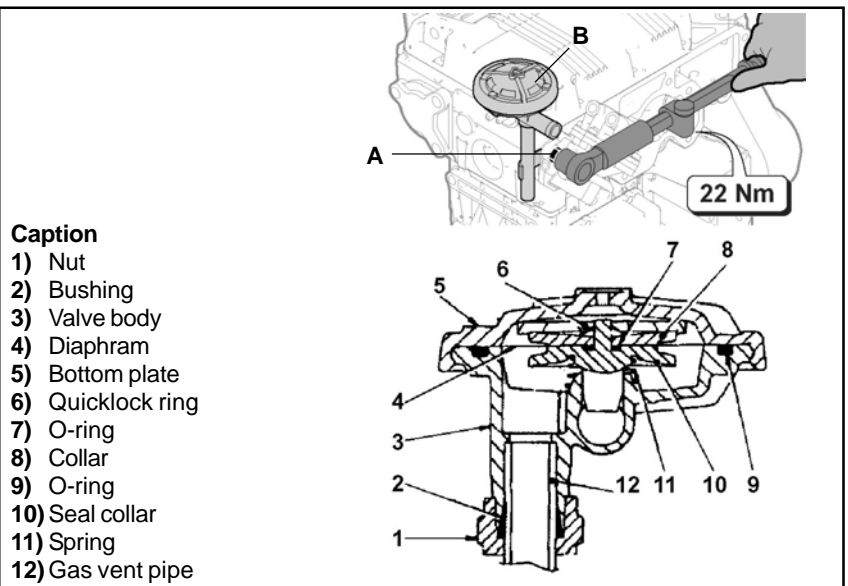
- 4 - Mount the cover and fasten the screws.

8.12 REPLACING THE NEGATIVE-PRESSURE VENT VALVE

Important

Replacement may be carried out with the engine installed on the machine.

- 1 - Switch off the engine and leave to cool.
- 2 - Loosen nut (A).
- 3 - Loosen the clamps and disconnect the pipes.
- 4 - Take off the negative-pressure vent valve (B).
- 5 - Install the negative-pressure vent valve.
- 6 - Tighten the nut to a final torque of 22Nm.
- 7 - Connect the pipe to the coupling.

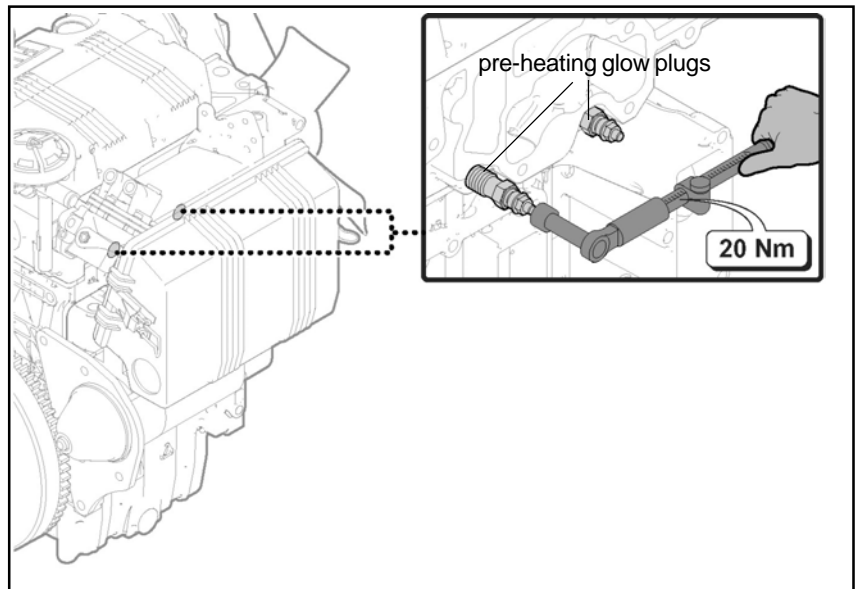


8.13 REPLACING THE PREHEATING GLOW PLUGS

Important

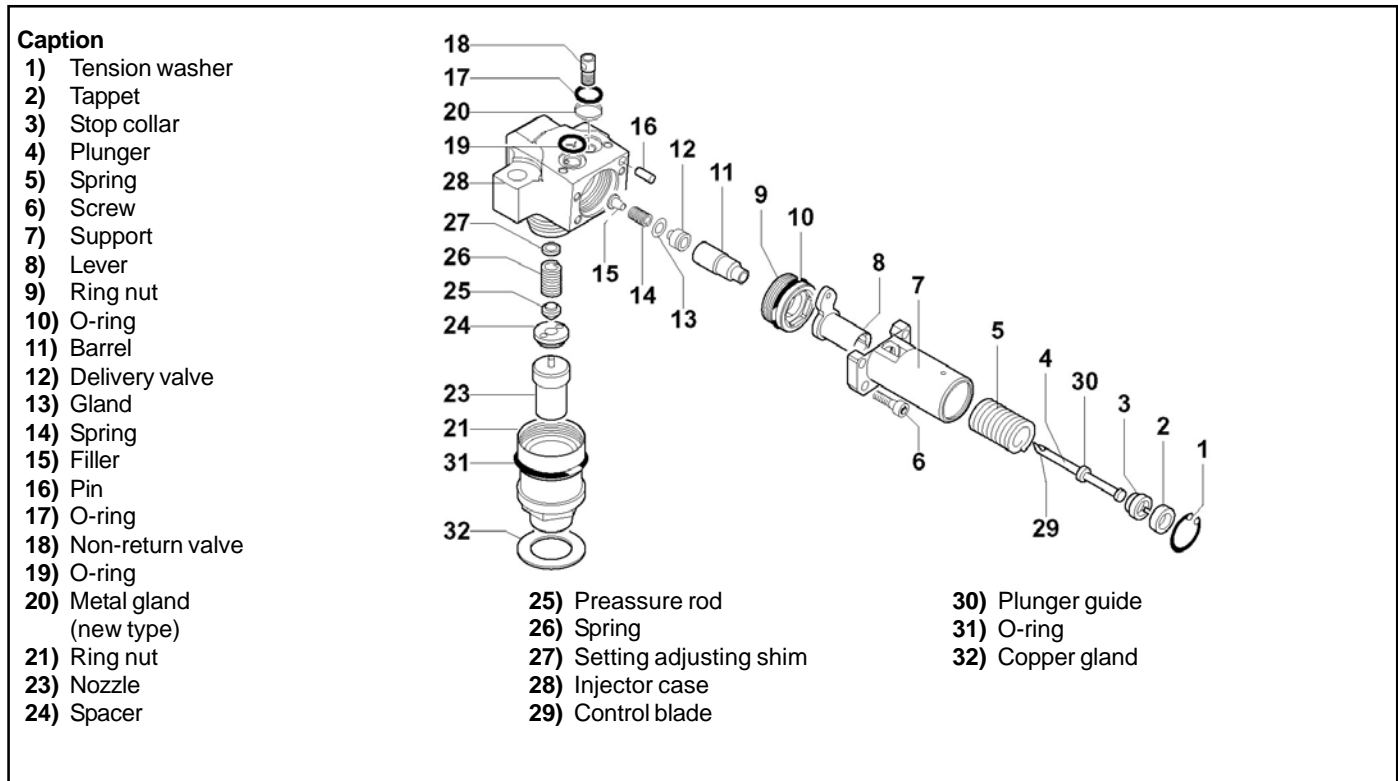
Replacement may be carried out with the engine installed on the machine.

- 1 - Switch off the engine and leave to cool.
- 2 - Remove the intake manifold (see "Disassembling the intake manifold").
- 3 - Disconnect the electric cable.
- 4 - Disconnect the preheating glow plugs.
- 5 - Install the new preheating glow plugs and tighten the screws to a torque of 20 Nm.
- 6 - Reconnect the electric cable.
- 7 - Mount the intake manifold (see "Assembling the intake manifold").



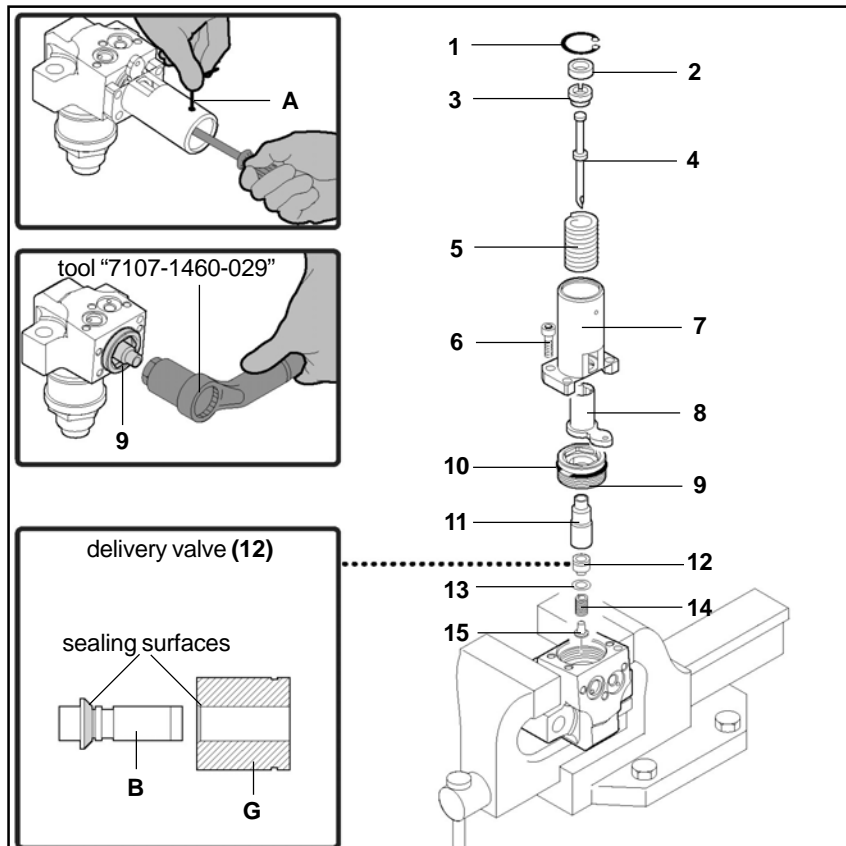
8.14 REPLACING INJECTOR PUMP PARTS

Exploded diagram of the injector pump
The figure shows the injector pump parts.



8.14.1 Pumping element replacement

- 1 - Press down hard on the pump collar to fit the pin (A).
 - 2 - Disassemble the lock ring (1).
 - 3 - Press down hard on the pump collar to remove the pin (A).
 - 4 - Remove the parts (2-3-4-5).
 - 5 - Loosen the screws (6).
 - 6 - Disassemble the support (7) and the lever (8).
 - 7 - Insert tool "7107-1460-029" and disassemble the ring nut (9).
- Important**
- Rotate in an alternating way the ring nut during disassembling to avoid damaging the O-ring (10).**
- 8 - Extract the barrel (11), the valve (12) as well as the parts (13-14-15).



- 9 - Check the good seal of the delivery valve (12) as well as of the pumping element (parts 4-11). If necessary, replace them with original spare parts.
- 10 - Assemble all parts (15-14-13).
- 11 - Assemble the delivery valve (12).

Important

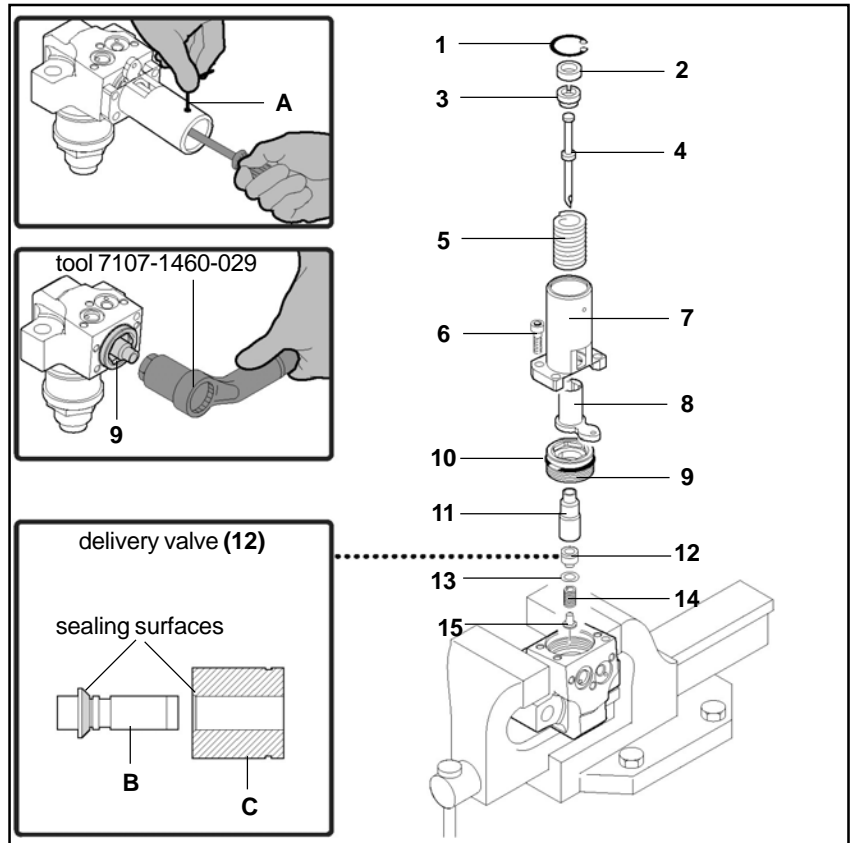
The needle (B) and the valve seat (C) must be assembled as shown in the figure.

- 12 - Assemble the barrel (11) and tighten the ring nut (9) provided with a new O-ring (10).

Important

Rotate in an alternating way the ring nut during assembling to avoid damaging the O-ring (10).

- 13 - Assemble in sequence all parts (5-4-3-2) on the support (7).
- 14 - Press down part (2) to fit the pin (A).
- 15 - Reassemble the stop ring (1).

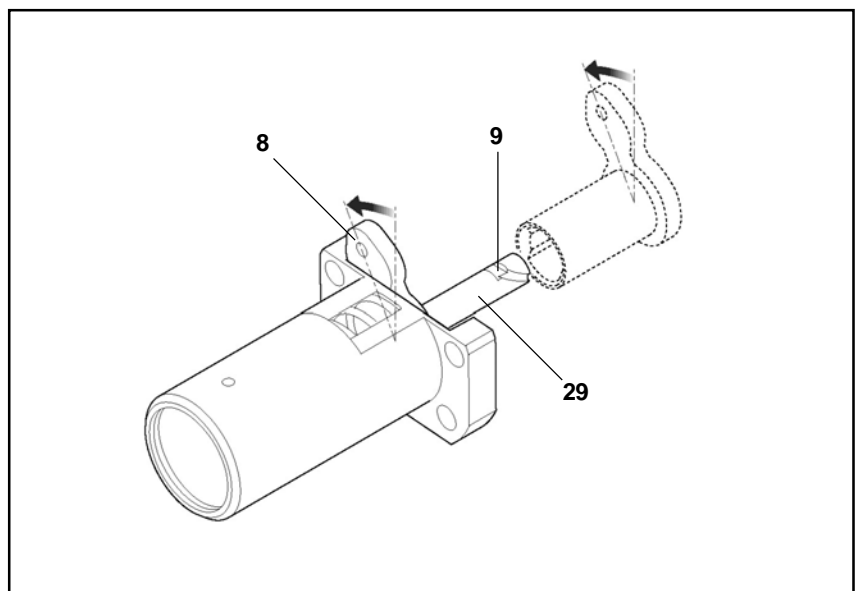


- 16 - Rotate the plunger (4) by means of the control blade (29) as shown in the figure.
- 17 - Insert the lever (8) and engage it in the plunger (4).

Caution - Warning

Check that the position of both lever (8) and plunger control blade (29) is the same as that shown in the figure. If the control blade is positioned in a different way, the engine may not run.

- 18 - Tighten the screws (6) to join the support to the injector pump case .
- 19 - Press down hard on the pump collar to remove the pin (A).

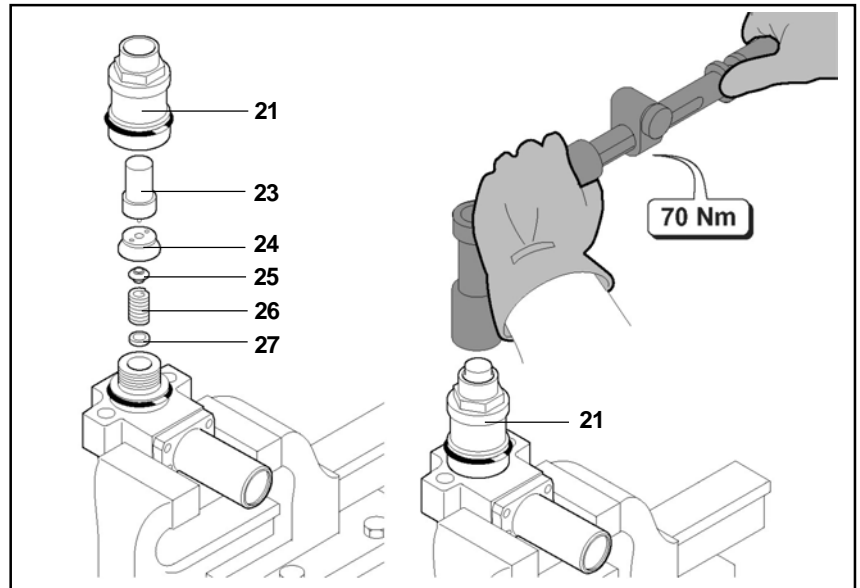


8.14.2 Replacing nozzle-injector

Important

Replacement may be carried out with the engine installed on the machine.

- 1 - Disassemble the injection pump (see "Disassembling injection pumps").
- 2 - Loosen the ring-nut (21).
- 3 - Extract the nozzle (23) and the parts (24-25-26-27).
- 4 - Check that all components are intact and, if necessary, replace them with original spare parts.
- 5 - Reassemble the parts (27-26-25-24).
- 6 - Assemble a new nozzle (23).
- 7 - Tighten the ring nut (21) to a final torque of 70 Nm.



Important

Check the setting (see "Injector pump setting") since it could be necessary to replace the adjusting shim (27) and the spring (26).

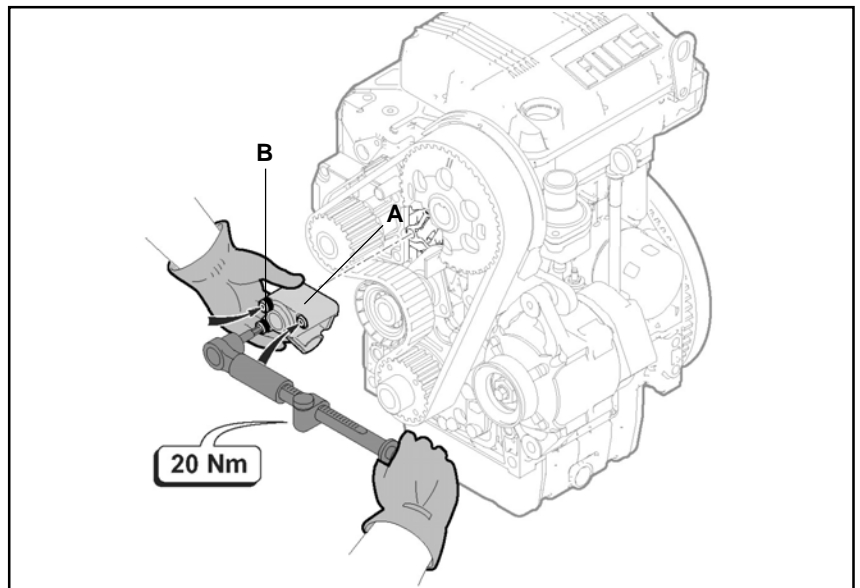
- 8 - Repeat the same operation on the other injector.
- 9 - Assemble the injector pump (see "Injector pump assembly").

8.15 REPLACING THE COOLING FAN SUPPORT

Important

Replacement may be carried out with the engine installed on the machine.

- 1 - Switch off the engine and leave to cool.
- 2 - Disassemble the cooling fan belt drive (see "Removing the cooling fan belt drive").
- 3 - Remove the belt drive cover (see "Disassembling timing belt casing").
- 4 - Remove the support (A).
- 5 - Install the new support.
- 6 - Tighten the screws (B) to a torque of 20 Nm.
- 7 - Mount the belt drive cover (see "Assembling the belt drive cover").
- 8 - Replace the cooling fan belt drive (see "Installation of the cooling fan belt drive")



A			
ACEA Standards,	14	Coolinf fan belt drive, removing,	30
Adjusting injection delivery,	60	Cooling fan belt drive, installation,	78
Adjusting injection delivery (with dyno brake)	61	Cooling fan blet (with external alternator), disassembling,	31
Adjusting injection delivery (without dyno brake),	60	Cooling fan blet (with internal alternator), disassembling,	31
Adjusting minimum and maximum idle speed rpms,	60	Cooling fan support, replacing,	93
Adjusting static injection timing,	55	Cooling fan, assembling,	80
Adjusting valve-rocker arm clearance,	52	Cooling, operating principle,	15
Air filter, replacing,	86	Crank gear and crankcase, removing,	36
Alternator - fan blet, replacing,	83	Crank gears and crankcase, overhauling,	41
Alternator load curve diagrams,	13	Crankcase and crank gear, removing,	36
Alternator, replacing,	87	Crankcase and crank gears, overhauling,	41
API/MIL sequences,	14	Crankcase and crankgear,	65
Assembling injection – pumps,	73	Crankcase and crankshaft, disassembling,	38
Assembling the belt drive cover,	77	Crankcase, assembling,	66
Assembling the camshaft,	71	Crankgear and crankcase, installation,	65
Assembling the cooling fan,	80	Crankshaft and crankcase, disassembling,	38
Assembling the crankcase,	66	Crankshaft axial clearanca, measuring,	67
Assembling the crankshaft,	66	Crankshaft flange (flywheel side), assembling,	67
Assembling the crankshaft flange (flywheel side),	67	Crankshaft, assembling,	66
Assembling the cylinder head,	71	Crankshaft, dimensional check and overhaul,	44
Assembling the exhaust manifold ,	80	Cylinder - piston classes and dimensions, table,	42
Assembling the fan belt drive ,	79	Cylinder head and components, installation,	70
Assembling the fan belt drive pulleys,	78	Cylinder head and components, overhaul,	47
Assembling the flywheel,	69	Cylinder head, assembling,	71
Assembling the intake manifold,	80	Cylinder head, checking and overhauling,	47
Assembling the mechanical fuel pump,	74	Cylinder head, disassembling,	36
Assembling the precombustion chamber,	70	Cylinder head, removing,	33
Assembling the rocker arm cover,	75	Cylinders and pistons, overhauling,	41
Assembling the rocker arms,	75	Cylinders, dimensional check and overhaul,	42
Assembling the speed governor and flow limiter,	72		
Assembling the timing belt ,	76	D	
Assembling the timing belt pulley,	76	Decanting device, overhauling,	47
Assembling the valves,	64	Diagram of timing belt rates,	55
		Dimensional check and overhaul of connecting rods,	45
B		Dimensional check and overhaul of crankshaft,	44
Balancing injection-pump delivery,	58	Dimensional check and overhaul of cylinders,	42
Bearings,	41	Dimensional check and overhaul of pistons,	42
Belt drive cover, assembling,	77	Dimensional check of sealing rings,	43
		Dimensional table of sealing rings,	43
C		Disassembling the camshaft,	36
Calibrating the injector,	53	Disassembling the connecting rod and piston,	39
Cam dimensions, table,	50	Disassembling the cooling fan belt (with external alternator),	31
Camshaft dimensions, table,	49	Disassembling the cooling fan belt (with internal alternator),	31
Camshaft, assembling,	71	Disassembling the crankcase and crankshaft,	38
Camshaft, checking and replacing,	49	Disassembling the cylinder head,	36
Camshaft, disassembling,	36	Disassembling the exhaust manifold,	30
Characteristic curve diagrams,	12	Disassembling the flywheel,	36
Checking and overhauling the cylinder head,	47	Disassembling the fuel pump,	33
Checking and overhauling the fuel pump,	46	Disassembling the injection-pumps,	34
Checking and overhauling the rocker arm pin,	48	Disassembling the intake manifold,	29
Checking and overhauling the speed governor,	53	Disassembling the oil pump,	37
Checking and overhauling the valves,	51	Disassembling the piston,	40
Checking and replacing the camshaft,	49	Disassembling the precombustion chamber,	34
Checking and replacing the fuel pump drive rod,	50	Disassembling the pulleys (camshaft and crankshaft),	32
Checking clearance volume,	52	Disassembling the rocker arm cover,	33
Checking oil preasure,	61	Disassembling the rocker arms,	33
Checking parallelism of the connecting rod axes,	45	Disassembling the speed governor and flow limiter,	35
Checking the timing belt rating,	54	Disassembling the timing belt,	32
Clearance table of sealing rings,	43	Disassembling the timing belt casing,	31
Clearance volume and head gasket values, table,	52	Disassembling the valves,	39
Clearance volume, checking,	52		
Clearance, valve - rocker arm, adjusting,	52	E	
Connecting rod / piston - engine block, installing,	65	Engine and manufacturer identification,	5
Connecting rod and piston, disassembling,	39	Engine block - piston/connecting rod, installing,	65
Connecting rod axes, checking parallelism,	45	Establishing injetion timing, conversion table,	57
Connecting rod dimensions, table,	45	Exhasut and intake manifolds, installing,	80
Connecting rods - pistons, pre-assembly,	64	Exhaust and intake manifolds, removing,	29
Connecting rods and half bearings, table of diameters,	44	Exhaust manifold, assembling,	80
Connecting rods, dimensional check and overhaul,	45	Exhaust manifold, disassembling,	30
Conversion table for establishing injection timing,	57	Exploded diagram of the Injector pump,	91
Coolant pump, replacing,	89	Exploded diagram of the speed governor,	53
Coolant thermostat, replacing,	88		

F		O	
Fan belt drive pulleys, assembling,	78	Oil filter, replacing,	85
Fan belt drive, assembling,	79	Oil pressure, checking,	61
Flow limiter and speed governor, assembling,	72	Oil pump, disassembling,	37
Flow limiter and speed governor, disassembling,	35	Oil pump, installing,	68
Flywheel ring gear, replacing,	88	Operating phases, general safety,	6
Flywheel, assembling,	69	Operating principle for cooling,	15
Flywheel, disassembling,	36	Operating principle for fuel injection,	16
Fuel injection, operating principle,	16	Operating principle for lubrication,	15
Fuel pump drive rod, checking and replacing,	50	O-rings,	41
Fuel pump, checking and overhauling,	46	Overhaul and dimensional check of connecting rods,	45
Fuel pump, disassembling,	33	Overhaul and dimensional check, Cylinders,	42
Fuel pump, mechanical, assembling,	74	Overhaul and dimensional check, pistons,	42
		Overhaul and dimensional check, crankshaft,	44
G		Overhaul of cylinder head and components,	47
General description of the engine,	9	Overhauling and checking the cylinder head,	47
General safety during operating phases,	6	Overhauling and checking the fuel pump,	46
General safety regulations,	6	Overhauling and checking the rocker arm pin,	48
Glossary and terminology,	6	Overhauling cylinders and pistons,	41
		Overhauling the crank gears and crankcase,	41
H		Overhauling the decanting device,	47
Half bearings and connecting rods, table of diameters,	44	Overhauls and tuning, recommendations,	41
Handling and lifting,	25		
Head gasket and clearance volume values, table,	52	P	
		Parallelismo assi biella, controllo,	45
I		Pin - rocker arm dimensions, table,	48
Idle speed rpms, minimum and maximum, adjusting,	60	Piston - cylinder classes and dimensions, table,	42
Injection - pumps, assembling,	73	Piston / connecting rod - engine block, installing,	65
Injection delivery (with dyno brake), adjusting,	61	Piston and connecting rod, disassembling,	39
Injection delivery (without dyno brake), adjusting,	60	Piston, disassembling,	40
Injection delivery, adjusting,	60	Pistons - connecting rods, pre-assembly,	64
Injection-pump delivery, balancing,	58	Pistons - sealing rings, pre-assembly,	63
Injection-pumps, disassembling,	34	Pistons and cylinders, overhauling,	41
Injector pump parts, replacing,	91	Pistons, dimensional check and overhaul,	42
Injector pump, exploded diagram,	91	Pre-assembly of connecting rods - pistons,	64
Injector, calibrating,	53	Pre-assembly of sealing rings - pistons,	63
Injection timing, conversion table for establishing,	57	Precautions when the engine is installed on the machine,	7
Installation of crankgear and crankcase,	65	Precautions when the engine is on the rotating stand,	7
Installation of cylinder head and components,	70	Precombustion chamber, assembling,	70
Installation of the cooling fan belt drive,	78	Precombustion chamber, disassembling,	34
Installing piston/connecting rod - engine block,	65	Pre-heating glow plugs, replacing,	90
Installing the assemblies, recommendations,	63	Preparing the engine for operation (istalled),	27
Installing the intake and exhaust manifolds,	80	Preparing the engine for operation (uninstalled),	26
Installing the oil pump,	68	Protective treatment,	26
Installing the timing belt drive,	76	Pulleys (camshaft and crankshaft), disassembling,	32
Installing valves,	64	Pumping element replacement,	91
Intake and exhaust manifolds, installing,	80	Purpose of the manual,	5
Intake and exhaust manifolds, removing,	29		
Intake manifold, assembling,	80	R	
Intake manifold, disassembling,	29	Raccomandazioni per l'installazione dei gruppi,	63
		Recommendations for installing the assemblies,	63
L		Recommendations for overhauls and tuning,	41
Looking for malfunctions,	23	Recommendations for removing the assemblies,	29
Lubricants,	14	Recommendations for replacing parts,	83
Lubrication, operating principle,	15	Recommended oil,	14
		Removing the assemblies, recommendations,	29
M		Removing the cooling fan belt drive,	30
Maggiorazioni semianelli di spallamento, tabella,	42	Removing the crank gear and crank case,	36
Maintenance, engine, routine,	21	Removing the cylinder head,	33
Maintenance, special tools and equipment,	19	Removing the exhaust and intake manifolds,	29
Malfunctions, looking for,	23	Removing the timing belt drive,	31
Manufacturer and engine identification,	5	Replacing the pre-heating glow plugs,	90
Measuring crankshaft axial clearance,	67	Replacing and checking the camshaft,	49
Mechanical fuel pump, assembling,	74	Replacing injector pump parts,	91
		Replacing parts, recommendations,	83
N		Replacing the air filter,	86
Negative-preassure vent valve, replacing,	90	Replacing the alternator,	87
Nozzle-injector, replacing,	93	Replacing the alternator - fan belt,	83
		Replacing the coolant pump,	89
		Replacing the coolant thermostat,	88
		Replacing the cooling fan support,	93
		Replacing the flywheel ring gear,	88
		Replacing the negative-preassure vent valve,	90

Replacing the nozzle-injector,	93
Replacing the oil filter,	85
Replacing the starter motor,	87
Replacing the thermostatic valve,	89
Replacing the timing belt,	85
Rocker arm - pin dimensions, table,	48
Rocker arm - valve clearance, adjusting,	52
Rocker arm cover, assembling,	75
Rocker arm cover, disassembling,	33
Rocker arm pin, checking and overhauling,	48
Rocker arm, disassembling,	33
Rocker arms, assembling,	75
Routine engine maintenance,	21

S

SAE Classification,	14
Safety and environmental impact,	7
Sealants, table,	21
Sealing rings - pistons, pre-assembly,	63
Sealing rings, clearance table,	43
Sealing rings, dimensional check,	43
Sealing rings, dimensional table,	43
Shaft seals,	41
Special tools and equipment for maintenance,	19
Specific fuel consumption, table,	61
Speed governor and flow limiter, assembling,	72
Speed governor and flow limiter, disassembling,	35
Speed governor, checking and overhauling,	53
Speed governor, exploded diagram,	53
Springs - valve stems - valve guides dimensions, table,	51
Starter motor, replacing,	87
Static injection timing, adjusting,	55
Storing the engine (installed),	25
Storing the engine (uninstalled),	25

T

Tabella classi e dimensioni cilindri - pistoni,	42
Table of cam dimensions,	50
Table of camshaft dimensions,	49
Table of connecting rod dimensions,	45
Table of cylinder - piston classes and dimensions,	42
Table of diameters of connecting rods and half bearings,	44
Table of dimensions for springs - valve stems - valve guides,	51
Table of dimensions pin-rocker arm,	48
Table of head gasket and clearance volume values,	52
Table of sealants,	21
Table of sealing rings clearance,	43
Table of specific fuel consumption,	61
Table of tightening torques,	19
Table of uprated shoulder half-rings,	44
Technical specifications,	10
Terminology and glossary,	6
Thermostatic valve, replacing,	89
Tightening torques, table,	19
Timing belt casting, disassembling,	31
Timing belt drive, installing,	76
Timing belt drive, removing,	31
Timing belt pulley, assembling,	76
Timing belt rates, diagram,	55
Timing belt rating, checking,	54
Timing belt, assembling,	76
Timing belt, disassembling,	32
Timing belt, replacing,	85

U

Uprated shoulder half-rings, table,	44
Using this manual,	5

V

Valve - rocker arm clearance, adjusting,	52
Valve adjustments,	54
Valve guides - springs - valve stems dimensions, table,	51
Valve stems - springs - valve guides dimensions, table,	51
Valves, assembling,	64
Valves, checking and overhauling,	51
Valves, disassembling,	39
Valves, installing,	64

W

Warranty clauses,	6
Wiring diagram,	17



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